MIGWELD 316LSi

MIG/MAG Wires [GMAW]

Stainless and high alloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14343-A : G 19 12 3 LSi DIN 8556 : S-GX2 CrNiMo19 12 3 AWS A-5.9 : ER 316 LSi W.Nr. : 1.4430	TUV DB	Power generation industry Constructions & Engineering Metallurgy (Steelworks) Mining Petrochemical and chemical industry Agriculture Light construction and hobby

- Solid welding wire for welding acid-resistant steels with the addition of Mo.
- The weld is characterized by good resistance to general and intergranular corrosion.
- Recommended for use in more aggressive environments, e.g. diluted hot acids.
- It has good resistance to chloride pitting corrosion.

Application

Pulp and paper equipment (boilers, evaporators), heat exchangers, dyeing equipment, film processing equipment, pipelines, offshore external construction materials, equipment for marine use, chemicals, dyes, paper, oxalic acid, fertilizer, food industry, boat equipment, heat exchangers, tables and laboratory equipment, brewery equipment, dairy and pharmaceutical equipment, oil refining equipment, textile industry equipment, ozone generators, wastewater filters, exhaust manifolds, furnace parts, valve and pump parts.

Base material

PN	EN 10088-1/2	W.Nr.	AISI/ASTM
0H17N12M2T	X5 CrNiMo 17 12 2	1.4401	316
00H17M14M2	X2 CrNiMo 17 13 2	1.4404	316L
	X2 CrNiMo 18 14 3	1.4435	316L
H17N14M2	X5 CrNiMo 17 13 3	1.4436	316
	X6 CrNiMoNb 17 12 2	1.4580	316Cb
	X10 CrNiMoTi 18 12	1.4573	316Ti
	X10 CrNiMoNb 18 12	1.4583	318
	G-X 6CrniMo18 10	1.4408	316H
	G-X 10CrNiMo18 9	1.4410	
H17N13M2T, H18N10MT	X6 CrNiMoTi17 12 2	1.4571	316Ti
	X3 CrNiMoN17 11 2	1.4406	316LN
	X2 CrNiMoN17 13 3	1.4429	
0H18N12Nb	X6 CrNiNb18 10	1.4550	347
	G-X5 CrNiNb19 10	1.4552	Cf-8C
	X5 CrNiMo17 13	1.4449	318
	G-X5 CrNiMoNb18 10	1.4581	318
	G-X6 CrNiMo18 12	1.4437	CF-8M

Typical chemical composition %

C	Si	Mn	Cr	Ni	Mo
<0,025	0,70	1,75	19,00	11,50	2,75

Typical mechanical properties

Yield strength Re [N/mm2]	>320
Tensile strength Rm [N/mm2]	550-650
Elongation A5 [%]	>30
Impact energy Kv [J]	>80J (20°C) / >32J (-196°C) /
Wire/rod type	solid
Welding current	
Welding positions	
Shielding gases acc. to EN ISO 14175	I1 - Ar / M12 - Ar + 0.5 - 5% CO2 / M13 - Ar + 0.5 - 3% O2 /

Welding parameters and packing

⌀	Welding current [A]	Voltage [V]	Weight of packet [kg]
0,8	100-160	18-22	15,0
1,0	140-200	18-24	15,0
1,2	170-260	20-28	15,0
1,6	220-350	24-36	15,0

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