TIGWELD 316LSi

TIG Rods [GTAW]

Stainless and high alloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14343-A : W 19 12 3 LSi DIN 8556 : SG-X2 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

- Rods for welding acid-resistant steel with the addition of Mo.
- The weld is characterized by good resistance to general and intergranular corrosion.
- For use in more aggressive environments, e.g. dilute hot acids.
- 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

DIN	W.Nr.	AISI/ASME	PN
X5CrNiMo 18 10	1.4401		0H17N12M2T
X5CrNiMo 18 12	1.4436		
X2CrNiMo 17 12 2	1.4404	316L	00H17M14M2
X2CrNiMo 18 14 3	1.4435	316L	
X2CrNiMoN 17 11 2	1.4406	316LN	H17N14M2
X2CrNiMoN 17 13 3	1.4429		
GX5CrNiMo 19 11	1.4408	CF-8M	
X6CrNiMoTi 17 12 2	1.4571	316Ti	H17N13M2T, H18N10MT
X6CrNiMoNb 17 12 2	1.4580	316CB	
X6CrNiNb 18 10	1.4550	347	
GX5CrNiNb 19 10	1.4552	CF-8C	
X10 CrNiMoTi 18 12	1.4573		
X10 CrNiMoNb 18 12	1.4583	318	
GX2CrNiMo 19 11 2	1.4409		

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 (-110°C) /
Wire/rod type	solid
Welding current	
Welding positions	
Shielding gases acc. to EN ISO 14175	I1 - Ar / I3 - Ar + >0-95% He /

Welding parameters and packing

ø	Length [mm]	Weight of packet [kg]
1,0	1000 /	5,0
1,2	1000 /	5,0
1,6	1000 /	5,0
2,0	1000 /	5,0
2,4	1000 /	5,0
3,2	1000 /	5,0
4,0	1000 /	5,0

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