BÖHLER AWS ER316LSi

Solid wire high-alloyed, stainless

Classifications

EN ISO 14343-A	EN ISO 14343-B	AWS A5.9
G 19 12 3 L Si	SS316LSi	ER316LSi

Characteristics and typical fields of application

GMAW solid wire designed for first class welding, good wetting and feeding characteristics as well as reliable corrosion resistance up to +400 °C.

Low temperature service down to –196 °C.

Base materials

1.4401 X5CrNiMo17-12-2, 1.4404 X2CrNiMo17-12-2, 1.4435 X2CrNiMo18-14-3, 1.4436 X3CrNiMo17-13-3, 1.4571 X6CrNiMoTi17-12-2, 1.4580 X6CrNiMoNb17-12-2, 1.4583 X10CrNiMoNb18-12, 1.4409 GX2CrNiMo19-11-2

UNS S31603, S31653; AISI 316L, 316Ti, 316Cb

Typical analysis of solid wire

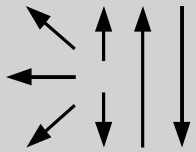
	C	Si	Mn	Cr	Ni	Mo
wt.-%	0.02	0.8	1.7	18.4	12.4	2.8

Mechanical properties of all-weld metal

Condition	Yield strength $R_{p0,2}$	Tensile strength R_m	Elongation (L_0=5d_0)	Impact work ISO-V KV J	
	MPa	MPa	%	+20 °C	–196 °C
u	**420** (≥ 320)	**560** (≥ 510)	**35** (≥ 25)	**70**	≥ 32

u untreated, as welded – shielding gas Ar + 2.5 % CO_2

Operating data



Polarity:	Shielding gases:	ø (mm) BS300, S300
DC (+)	Argon + max. 2.5 % CO_2	0.8
		0.9
		1.0
		1.2
		1,6

Approvals

TÜV (12937.), DB (43.132.39), CE

All information provided is based upon careful investigation and intensive research.
However, we do not assume any liability for correctness and information is subject to change without notice.