

**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**

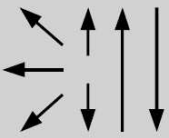
	C	Si	Mn	Cr	Ni	Mo
wt.-%	0.02	0.8	1.7	18.4	12.4	2.8

**Mechanical properties of all-weld metal**

Condition	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J	
	MPa	MPa	%	+20 °C	-196 °C
u	<b>420</b> (≥ 320)	<b>560</b> (≥ 510)	<b>35</b> (≥ 25)	<b>70</b>	≥ 32

u untreated, as welded – shielding gas Ar + 2.5 % CO<sub>2</sub>

**Operating data**

	<b>Polarity:</b> DC (+)	<b>Shielding gases:</b> Argon + max. 2.5 % CO <sub>2</sub>	<b>ø (mm) BS300, S300</b>
			0.8
			0.9
			1.0
			1.2
1,6			

**Approvals**

TÜV (12937.), DB (43.132.39), CE