

Stainless steel 316L TIG filler metal in rod form for welding austenitic stainless steels with and without molybdenum (316, 316L, 316 Ti/Nb304, 304L). It is recommended as a first pass in all instances where consistent penetration and density are required.

Classification

AWS A5.9 : ER 316L

EN ISO 14343-A : W19 12 3 L

Applications

- Piping, thin-walled structures up to and including 3 mm and for penetration passes,
- Reserved for assemblies not exceeding 350°C operating service temperature.

Product benefits

- Suitable for corrosive environments, acids, chlorine, etc.
- Corrosion-resistant.

Chemical properties

Cmax %	Mn %	Si %	Cr %	Ni %	Mo %	Smax %	Pmax %	Fe
0.025	1.80	0.45	19.00	12.00	2.60	0.02	0.02	Base

Mechanical properties

Rp 0,2	Rm	A 5 d	KV -196°C
410 Mpa	600 Mpa	35%	45 J

Recommendations

Ø electrode (mm)	1,6	2	2,4
thickness (mm)	1,5 ▶ 2,0	2,0 ▶ 2,5	2,5 ▶ 3,0
welding current (A)	60 ▶ 95	90 ▶ 110	120 ▶ 150

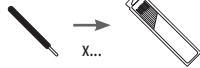
Gas protection in accordance with EN ISO 14175

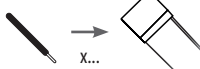
100% Argon (I1) : 6-12 l/min

Reverse: Argon / Nitrogen: 3-6 l/min



Packaging

Réf.	Ø (mm)	length (mm)	
087262	Ø 1.6	330	60
087279	Ø 2.0	330	40

Réf.	Ø (mm)	length (mm)	
087125	Ø 1.6	1000	920
087200	Ø 2.0	1000	590
087149	Ø 2.4	1000	410