

ER316LSi Solid Stainless Steel Mig Wire

Description

316LSi is a stainless steel MIG wire with high silicon levels to improve arc characteristics and improves weld edge wetting weld pool fluidity. ER316LSi used for welding of 316 and 316L grade stainless steels, in a wide range of applications including the fabrication of pipe and plate. The weld metal has a high resistance to pitting and crevice corrosion by non-oxidizing acids. Its low carbon content increases resistance to corrosion. 316LSi would be considered the most widely used stainless steel MIG wire. Precision layer winding technologies ensure smooth, virtually trouble-free feeding.

SHIELDING GAS:

98%Argon 2% C02

95%Argon 5% C02

CONFORMANCES:

AWS A5.9: ER316LSi

AS/NZS ISO 14343 B-SS316LSi

ISO 14343-A G 19 12 3 L Si

TYPICAL APPLICATIONS

316LSi stainless steel MIG wire is used for the welding of 18Cr/8Ni and 18Cr/8Ni/3Mo type stainless steels. 316LSi Mig and Tig Wire is most suitable for the welding of 316, 318 and 316L alloys. Also suitable for the welding of 301, 302, 304, 321, 347, 410 and 430 alloys.

WIRE CHEMICAL COMPOSITION wt%

	C	Si	Mn	P	S	Cr	Ni	Mo	Cu
MAX	0.030	1.000	2.500	0.030	0.030	20.00	14.000	3.000	0.750
MIN	-	0.650	1.000	-	-	18.500	11.000	2.000	-
Typical	0.010	0.890	1.530	0.024	0.001	18.590	11.570	2.530	0.170

TYPICAL MECHANICAL PROPERTIES OF WELD METAL

Yield MPa	Tensile Strength MPa	Elongation %	Absorbed Energy (J)	Test Temp (C)
380	550	41	39	-196

WELDING POSITIONS

All Positional

CURRENT RANGE DC+ (For Guidance Only)

Diameter	0.9mm	1.0mm	1.2mm
Current Range (A)	60-220	80-240	110-260
Voltage Range (V)	22-25	23-26	24-32
Gas Flow 98%Ar+2%C02	18-20 L/min	18-20 L/min	18-20 L/min

Pulse parameters: Peak current 300 - 400 A