SI 316L

Submerged Arc Welding Wire - Stainless Steels

Standards

AWS/ASME SFA - 5.9	ER316L
EN ISO 14343 - A	S 19 12 3 L
TS EN ISO 14343 - A	S 19 12 3 L
DIN M. No.	1.4430

Properties and Applications

Austenitic stainless steel welding wire for submerged arc welding of unstabilized or stabilized high corrosion resisting Cr-Ni-Mo stainless steels. Used in combination with SIF 501 and SIF 502 submerged arc welding fluxes. Due to it's low carbon content, resistant to intergranular corrosion up to 400°C. Especially used in welding tanks, pipes and equipments which are used in chemical, petrochemical, paint, paper and shipbuilding industries, etc.

Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Cr	Ni	Mo
Welding Wire	0.02	0.40	1.80	18.50	12.00	2.70

Typical Chemical Values of Weld Metal

Welding Flux	Type of Analysis	C	Si	Mn	Cr	Ni	Mo
SIF 502	Weld Deposit	0.02	0.70	1.25	19.00	11.00	2.70
SIF 501	Weld Deposit	0.02	0.35	1.65	18.00	10.00	2.50

Typical Mechanical Values of Weld Metal

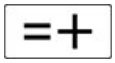
Test Condition	Welding Flux	Yield Strength (N/mm²)	Tensile Strength (N/mm²)	Elongation A5 (%)	Charpy V-Notch Properties (J)		
As welded	SIF 502	400	570	34	20°C → 70	-60°C → 55	-196°C → 45
As welded	SIF 501	420	570	38	20°C → 75	-60°C → 55	-196°C → 45

Application Information

Welding Positions

PA PB

Polarity:



Welding Parameters & Efficiency

Diameter (mm)
2.40
3.20

Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
43003IXAM2	2.40	25 kg	25.90	1	25.90	Wire Basket Spool (K435)
43003LXAM2	3.20	25 kg	25.90	1	25.90	Wire Basket Spool (K435)

Storage & Re-Drying Information

Shouldn t be exposed to high statical load and impact.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.