



GMAW / GTAW STAINLESS STEEL
MIGINOX 316LSi

316LSi TYPE STAINLESS STEEL SOLID WIRE



CLASSIFICATION : EN ISO 14343-A AWS A/SFA 5.9 **APPROVALS :**

G 19 12 3 Lsi

ER316LSi

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KEY FEATURES :

- An extra low carbon 19Cr/12Ni/Mo type stainless steel solid wire
- High Si content improves wetting characteristics
- High resistance against intergranular corrosion
- Resistant to SCC, hot cracking and chemical attack up to 850°C
- Offers improved corrosion & pitting resistance in marine and industrial environment
- Radiographic quality welds

WELDING POSITION :



DCEP

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
98Ar/2O ₂ or Ar/1-5CO ₂	15-22	10-20

TYPICAL APPLICATIONS :

- Welding austenitic alloys represented by AISI 316, 316L, 317, 317L, 318 types
- Joining similar grade wrought and cast material
- Application in textile processing, Naval and Chemical environments, Paper and pulp, Paint and dye industries
- Cladding stainless steels

STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

	C	Mn	Si	Cr	Ni	Mo	S	P
Specification	0.03 max	1.0-2.5	0.65-1.0	18.0-20.0	11.0-14.0	2.0-3.0	0.03 max	0.03 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%
Specification	As Welded	490 min	30 min

Mechanical properties will vary with the type of shielding gas used.

PACKING DATA :

Ø, mm	Kg/Spool
0.8	12.5
1.2	12.5
1.6	12.5
2.0	12.5