

Standards

TS EN ISO 14343-A	: G Z 19 12 3 L Si
EN ISO 14343-A	: G Z 19 12 3 L Si
AWS A5.9	: ER 316 LSi

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Cr	Ni	Mo
0.02	0.80	1.6	18.5	11.5	2.2

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation ((L ₀ =5d ₀) (%))
min. 400	550 - 700	min. 63 J	min. 30

Typical Base Material Grades

- X2 CrNiMo 1814 3, X5 CrNiMo 17 13 3, X2 CrNiMo 1713 2,, X5 CrNiMo 1712 2, X6 CrNiMoTi 17 12 2, X6 CrNiMoNb 17 12 2, X2 CrNiMoN 1713 3, X2 CrNiMoN 1712 2
- AISI: 316, 316Cb, 316L, 316Ti

Features and Applications

- MIG welding of 13% ferritic stainless steels, high-carbon or stabilized stainless steels of type 316 and low carbon stainless steels of type 316 L, used in machinery and equipment parts of production plants for food, chemical, drug, textile and similar kinds of industries
- As shielding gas, Ar+ %2.5 O₂ or Ar+ %2.5 CO₂ mixed gas is used
- Maintenance of resistance to intergranular corrosion at temperature values up to 400°C.
- Resistance to low temperatures varying at values down to -196°C

Welding Positions



Current Type

MIG D.C.(+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
	mm	inch		
6011100348	0,8	0.030"	12.5	BS 300
6011100398	1	0.040"	15	BS 300
6011100349	1,2	0.047"	15	BS 300
6011100350	1,6	0.062"	15	BS 300

Approvals: CE, SEPRO