

316S96

MIG (GMAW)

SOLID WIRE FOR TIG OF 316H STAINLESS STEEL

PRODUCT DESCRIPTION

Solid wire for TIG, which can not only be used in conjunction with E316H-16, but also with 178.2.RCF and other 300H consumables.

CLASSIFICATIONS

AWS A5.9M	ER316H
ISO 14343-A	19 12 3 H
ISO 14343-B	SS316H

ASME IX QUALIFICATION

QW432	F-No --
QW442	A-No 8

CHEMICAL COMPOSITION (WELD METAL WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	FN
Min.	0.04	1.0	0.30	--	--	18.0	11.0	2.0	--	3
Max.	0.08	2.5	0.65	0.02	0.025	20.0	14.0	3.0	0.3	8
Typical	0.05	1.8	0.5	0.01	0.02	19	13	2.2	0.15	4

ALL-WELD MECHANICAL PROPERTIES

As welded	Typical
Tensile strength (MPa)	650
0.2% proof strength (MPa)	460
Elongation (%) 4d	35

TYPICAL OPERATING PARAMETERS

Shielding gas	Current	Diameter (mm)	Voltage
Argon	100A, DC-	2.4	12V

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
1.6	2.5	PE TUBE	T316S96-16
2.0	2.5	PE TUBE	T316S96-20
2.4	2.5	PE TUBE	T316S96-24

HIGH TEMPERATURE ALLOYS