

Lincoln® MIG 316LSi

Key Features

- High silicon level for increased puddle fluidity, better bead shape and edge wetting
- Low carbon wire to resist inter-granular corrosion (weld decay)
- Versatile wire designed to weld Cr-Ni-Mo austenitic stainless steels
- Precision layer wound wire assists feeding and resists wire tangles

Typical Applications

- 316 and 316L stainless steels
- Marine, chemical, oil, gas, food, dairy and many other industries
- Suitable for welding UNS Grades S31600, S31603, S31635, S31640

Conformances

AWS A5.9/A5.9M: ER316LSi

Welding Positions



Shielding Gas

- 98-99% Argon / 1-2 % O₂ [spray transfer]
- 98-99% Argon / 1-2% CO₂ [short circuit]
- Flow Rate: 15-20 L/min

Diameter / Packaging / Settings

Diameter mm	Part Number	Packaging	WFS ipm	Voltage volts	Current amps	CTWD mm
0.9	331069	Spool S300 15kg	120-475	18-22	60-160	10-15
1.2	331062	Spool S300 15kg	125-360	19-23	100-185	10-15
1.6	331066	Spool S300 15kg	175-300	25-28	250-390	15-20

Mechanical Properties - As required per AWS A5.9

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -196°C	FN WRC
Requirements - AWS ER316LSi	Not specified	Not specified	Not specified	Not specified	Not specified
Typical Results	430	600	42	>80	5-8

Wire Composition

	%C	%Mn	%Si	%Cr	%Ni	%Mo
Typical Results	0.02	1.62	0.74	18.5	12.3	2.3