

Blue Max[®] MIG 316LCF

Stainless • AWS ER316/316L

Key Features

- ▶ Controlled Low Ferrite (Range 3-5)
- ▶ Charpy V-Notch test results capable of exceeding 27 J (20 ft•lbf) @ -196°C (-320°F)
- ▶ Exceeds 15 mils (0.38 mm) of lateral expansion @ -196°C (-320°F)
- ▶ Q2 Lot[®] - Certificates showing actual wire chemistry available online
- ▶ Batch Managed Inventory

Conformances

AWS A5.9: ER316/316L
ASME SFA-A5.9: ER316/316L

Welding Positions

- ▶ All

Shielding Gas

- ▶ 98% Argon / 2% Oxygen

Typical Applications

- ▶ LNG Storage
- ▶ Cryogenic Vessels and Piping

Typical Base Metals

- ▶ 316L stainless steel

DIAMETERS / PACKAGING

Diameter in (mm)		33 lb (15kg) Steel Spool
0.035	(0.9)	ED034925
0.045	(1.1)	ED034926

MECHANICAL PROPERTIES⁽¹⁾

	Yield Strength ⁽²⁾ MPa (ksi)	Tensile Strength MPa (ksi)	Elongation %	Charpy V-Notch J (ft•lbf) -196°C (-320°F)	Lateral Expansion mils (mm) -196°C (-320°F)
Requirements AWS A5.9: ER316/316L As-Welded with 98% Ar/2% O ₂	Not Specified	Not Specified	Not Specified	Not Specified	Not Specified
Typical Performance⁽³⁾ As-Welded with 98% Ar/2% O ₂	410 (69)	580 (85)	36	42 (56)	27 (0.69)

⁽¹⁾Typical all weld metal ⁽²⁾Measured with 0.2% offset ⁽³⁾See test results disclaimer below

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(AWS ER316/316L)

Material Safety Data Sheets (MSDS) are available upon request.

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

CUSTOMER ASSISTANCE POLICY

The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

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