Primalloy® JMS-316LSi

Key Features

- Improved resistance to pitting and crevice corrosion in chloride environment
- Excellent weldability – Stable arc, low spatter, good welding puddle control brings outstanding bead appearance
- Superb feedability – Unique manufacturing technology results in an even clean wire surface, stable wire feeding and low contact tip abrasion

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

- Ar + 2-5% CO2

Diameter / Packaging / Settings

Diameter mm	Part Number	Packaging	WFS in/min	Voltage volts	Current amps	CTWD mm
0.9	EMLM36LS090S015W00	Spool S300 15kg	120-475	19-25	60-210	10-15
1.2	EMLM36LS120S015W00	Spool S300 15kg	125-360	19-25	100-260	10-20

Mechanical Properties - As required per AWS A5.18

	Yield Strength MPa	Tensile Strength MPa	Elongation %
Typical Results (95%Ar / 5%CO2)	415	575	40

Deposit Composition

	%C	%Si	%Mn	%P	%S
Typical Results	0.028	0.83	2.05	0.02	0.01
	%Cr	%Mo	%Ni	%Cu	
	18.6	2.17	12.9	0.02	

Subject to change – this information is accurate to the best of our knowledge at the time of printing.