



T H E H A R R I S P R O D U C T S G R O U P  
A L I N C O L N E L E C T R I C C O M P A N Y  
4501 Quality Place • Mason, OH 45040 U.S.A Tel: 513-754-2000 Fax: 513-754-6015

## TECHNICAL SPECIFICATION SHEET

### 316L STAINLESS STEEL WELDING WIRE

#### STATEMENT OF LIABILITY- DISCLAIMER

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. The Harris Products Group and its affiliates shall have no liability in respect thereof.

#### NOMINAL COMPOSITION:

Carbon	.03% max.	Chromium	18.0-20.0%
Nickel	11.0-14.0%	Manganese	1.0-2.5%
Copper	.75% max.	Silicon	.30-.65% max.
Phosphorus	.03% max.	Sulfur	.03% max.
Molybdenum	2.0-3.0%	Iron	Balance
Normal Ferrite Range	5-12		

#### TYPICAL MECHANICAL PROPERTIES AS WELDED:

Yield Strength (psi)	59,000	Elongation	35%
Tensile Strength (psi)	88,000	Reduction of Area	40%
Charpy V	80 ft./lb. room temp.	Brinell Hardness	160 HB
Rockwell B Hardness	85 HRB		

#### APPLICATION:

This alloy is used to weld molybdenum-bearing alloys and similar alloys containing .03% maximum carbon

#### RECOMMENDED WELDING PARAMETERS:

##### \*GMAW (MIG) Parameters (DC Reverse Polarity) Electrode Positive Short-Circuiting transfer

<u>Wire Diameter</u>	<u>Amps</u>	<u>Volts</u>	<u>90% Helium + 7.5% Argon + 2.5% CO<sub>2</sub> (cfh)</u>	<u>Wire Feed (imp)</u>
.025	50-100	17-22	20-25	170-470
.030	60-125	17-22	20-25	150-430
.035	75-160	17-22	20-25	120-400
.045	100-200	17-22	20-25	100-240

##### \*GMAW (MIG) Parameters (DC Reverse Polarity) Electrode Positive Spray transfer

<u>Wire Diameter</u>	<u>Amps</u>	<u>Volts</u>	<u>Argon / 1-2% O<sub>2</sub></u>	<u>Wire Feed (imp)</u>
.025	140-200	24-27	25	450-660
.030	160-225	24-28	25	440-650
.035	180-300	24-29	30	430-500
.045	200-450	24-30	30-35	220-400
1/16	225-500	24-32	40	110-210

All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

Additional information available at our web site: [www.harrisproductsgroup.com](http://www.harrisproductsgroup.com)

08/08 MK



T H E H A R R I S P R O D U C T S G R O U P  
A L I N C O L N E L E C T R I C C O M P A N Y

4501 Quality Place • Mason, OH 45040 U.S.A Tel: 513-754-2000 Fax: 513-754-6015

TECHNICAL SPECIFICATION SHEET

**\*GTAW (Tig) Parameters (DCSP) Electrode negative**

<u>Material</u>	<u>2% Thoriated</u>	<u>Filler Wire Size</u>	<u>Amps</u>	<u>Gas Cup</u>	<u>Argon(cfh)</u>
1/16"	1/16"	1/16"	80-120	3/8	20
3/32"	1/16"	1/16"	100-130	3/8	20
1/8"	3/32"	1/16"	120-150	7/16	20
3/16"	3/32"	3/32"	150-250	7/16	25
1/4"	1/8"	1/8"	200-350	1/2	25
1/2"	1/8"	1/8"	235-375	1/2	25

**\* All parameters are suggested as basic guidelines and will vary depending on joint design, number of passes and other factors.**

**SPECIFICATION COMPLIANCE: ANSI/AWS A5.9 &ASME SFA 5.9 ER 316L**

**WARNING: PROTECT yourself and others. Read and understand this information.**

**FUMES AND GASES can be hazardous to your health.**

**ARC RAYS can injure eyes and burn skin.**

**ELECTRIC SHOCK can KILL.**

- Before use, read and understand the manufacturer’s instructions, Material Safety Data Sheets (MSDSs), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- Do not touch live electrical parts.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 550 N.W. LeJeune Road, Miami, Florida 33126; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402

All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

Additional information available at our web site: [www.harrisproductsgroup.com](http://www.harrisproductsgroup.com)

08/08 MK