Lincoln TIG 316LSi

CLASSIFICATION

AWS A5.9 - ER316LSi
ISO 14343-A - W 19 12 3 LSi

GENERAL DESCRIPTION

Solid rod with extra low carbon for welding stainless CrNiMo-steels
With increased silicon for improved wettability

SHIELDING GASES (ACC. ISO 14175)

I1 Inert gas Ar (100%)

APPROVALS

CE

+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Ni	Mo
0.03	1.9	0.8	18.5	12	2.7

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	0.2% proof strength (N/mm²)	Tensile strength (N/mm²)	Elongation (%)	Impact ISO-V(J) +20°C	Impact ISO-V(J) -196°C
Typical values	I1	AW	484	624	32	100	82

MATERIALS TO BE WELDED

Steel grades	EN 10088-1/-2	EN 10213-4	Mat. Nr	ASTM/ACI A240/A312/A351	UNS
Extra low carbon (C < 0.03%)					
	X2CrNiMo17 12 2		1.4404	(TP)316L	S31603
				CF-3M	J92800
	X2CrNiMo18 14 3		1.4435	(TP)316L	S31603
	X2CrNiMoN 17 11 2		1.4406	(TP)316LN	S31653
	X2CrNiMoN 17 13 3		1.4429		
Medium carbon (C > 0.03%)					
	X4 CrNiMo 17 12 2		1.4401	(TP)316	S31600
	X4 CrNiMo 17 13 3		1.4436		
	GX5 CrNiMo 19-11		1.4408	CF 8M	J92900
Ti-,Nb stabilized					
	X6 CrNiMoTi 17 12 2		1.4571	316 Ti	S31635
	X6 CrNiMoNb 17 12 2		1.4580	316 Cb	S31640
	X6 CrNiNb 18-10		1.4550	(TP)347	S34700
		GX5 CrNiNb 19-10	1.4552	CF-8C	J92710

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.2	1.6	2.0	2.4	3.2
Unit : 5 kg tube	X	X	X	X	X

Other sizes and packaging on request

Note : Cut length = 1000 mm