

## ER316LCF SAW

## CLASSIFICATION

AWS A5.9M	ER316L
EN ISO 14343-A	S 19 12 3 L
EN ISO 14343-B	SS316L

## CURRENT TYPE

DC+

## CHEMICAL COMPOSITION (WEIGHT %), WIRE

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	FN
Min.		1.0	0.30			18.0	11.0	2.5		3
Max.	0.025	2.0	0.65	0.020	0.030	20.0	14.0	3.0	0.3	8
Typical	0.01	1.4	0.5	0.01	0.015	18.5	12.8	2.6	0.15	6

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

As welded	Min.	Typical
Tensile strength (MPa)	510	560
0.2% Proof strength (MPa)	320	400
Elongation (%) 4d	30	41
5d	25	37
Impact ISO-V (J) -130°C		> 45
-196°C		40
Lateral expansion* (mm) -196°C	0.38	0.5

\*ER316LCF SAW wire batch tested, with P2007 flux for Charpy lateral expansion >0.38mm at -196°C.

## PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
2.4	SPOOL	25.0	SAER316LCF24

## 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.

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.eu](http://www.lincolnelectric.eu) for any updated information.