SUPERMIG 316LSi

MIG (GMAW)

SOLID WIRE FOR MIG

PRODUCT DESCRIPTION

Solid wire for MIG welding.

CLASSIFICATIONS

AWS A5.9M	ER316LSi
ISO 14343-A	G 19 12 3 LSi
ISO 14343-B	SS316LSi
Approvals	TÜV, LRS

ASME IX QUALIFICATION

QW432	F-No 6
QW442	A-No 8

CHEMICAL COMPOSITION (WIRE WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	FN
Min.	--	1.0	0.65	--	--	18.0	11.0	2.5	--	3
Max.	0.03	2.0	1.00	0.020	0.030	20.0	14.0	3.0	0.3	10
Typical	0.01	1.4	0.8	0.01	0.015	18.5	12.8	2.6	0.15	6

ALL-WELD MECHANICAL PROPERTIES

As welded		**Min.**	**Typical**
Tensile strength (MPa)		510	570
0.2% proof strength (MPa)		320	435
Elongation (%)	4d	30	42
	5d	30	40
Impact ISO-V(J)	-130°C	--	> 70
	-196°C	--	30-60
Hardness cap/mid	(HV)	--	200/220

* See data sheet B-38 for as-welded cryogenic applications at –196°C.

TYPICAL OPERATING PARAMETERS

Shielding gas	**Current**	**Diameter (mm)**	**Parameters**
Ar+2%O_2*	DC+	1.2	260A, 26V

* Also proprietary Ar and Ar-He gas mixtures with < 3%CO_2.

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
0.8	15	S300	MER316LSI-08
0.9	15	S300	MER316LSI-09
1.0	15	S300	MER316LSI-10
1.2	15	S300	MER316LSI-12

FUME DATA (WT % TYPICAL)

Fe	Mn	Cr^3	Ni	Mo	Cu	OES (mg/m³)
30	12	15	11	1.5	< 0.5	3.3

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.specialalloys.eu for any udpated information.