Techalloy® 316LHS

AWS ER316LSi

CONFORMANCES

AWS A5.9 ER316LSi

UNS S31688

ISO 14343:2009 (19 12 3 L Si)

Techalloy® 316LHS is similar to 316L, with higher silicon content for optimum ease and speed in MIG welding and smooth bead appearance. This alloy is intended for joining 316 type stainless steels.

DIAMETERS / PACKAGING

Diameter in	(mm)	MIG WIRE 33 lb (15 kg) Wire Basket
0.030	(0.8)	MG316LHS030667
0.035	(0.9)	MG316LHS035667
*0.045	(1.2)	MG316LHS045667
*0.062	(1.6)	MG316LHS062667

*Bulk packages available - Contact Lincoln Electric

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DEPOSIT COMPOSITION

	%C	%Cr	%Ni	%Mo	%Mn
Requirements AWS ER316LSi	0.03 max.	18.0 - 20.0	11.0 - 14.0	2.0 - 3.0	1.0 - 2.5
Typical Performance Techalloy® 316LHS	0.02	18.5	12.2	2.4	1.70
	%Si	**%P**	**%S**	**%Cu**	**FN**
Requirements AWS ER316LSi	0.65 - 1.0	0.03 max.	0.03 max.	0.75 max.	Not Required
Typical Performance Techalloy® 316LHS	0.80	0.01	0.009	0.13	5 - 10

TYPICAL OPERATING PROCEDURES

Process	Diameter in (mm)	Voltage (volts)	Amperage	Gas Flow	Gas
MIG	0.030 (0.8) 0.035 (0.9) 0.045 (1.2) 0.062 (1.6)	26-29 28-32 29-33	160-210 180-250 200-280	30-50 CFH	98/99% Argon + 2/1% Oxygen 97% Argon + 3% CO_2

Material Safety Data Sheets (MSDS) are available on our website at www.techalloy.com

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