

Key Facts

- Precision Layer wound wire
- Low Carbon content reduces the risk of Carbide precipitation.
- Easy starting and Smooth feeding wire
- Higher Silicon content improves weld edge wetting

Description

Mig wire similar to ER316L though with added silicon. The low carbon content ensures immunity from carbide precipitation and intergranular corrosion when welding low carbon stainless steel grades and the higher silicon level offers improved arc stability, bead shape and edge wetting.

Classifications, Approvals & Conformances

AWS A5.9 ER316LSi
 JIS Z3321 YS316LSi
 DIN8556 SG X2 CrNiMo 19 12

Recommended Shielding Gas

Ar or Ar/CO₂ mix.
 98/99% Argon + 2/1% Oxygen
 97% Argon + 3% CO₂

Welding Positions

All positions.

Applications

Ideal for welding stainless steel of similar composition (316 & 316L and in some cases 304 and 304L) as well as joining mild and low alloy. Use when good appearance is important.

- Food processing equipment
- Water processing filtration plants
- General stainless steel fabrications

Typical Wire Analysis

C - Carbon	Mn - Manganese	Si - Silicon	Cr - Chromium
< 0.03	1.0 – 2.5	0.65 – 1.00	18.0 – 20.0
Ni - Nickel	Mo - Molybdenum	S - Sulphur	P - Phosphorus
11.0 – 14.0	2.0 – 3.0	< 0.03	< 0.03
Cu - Copper	Fe - Iron		
<0.75	Remainder		

Typical Weld Mechanical Properties

0.2% Proof Stress:	> 390N/mm ²
Tensile Strength:	585N/mm ²
Elongation (5xD):	38%

Packaging & Ordering Information

Size	Packet	Part Number
0.8mm	1kg	200075
0.8mm	15kg	200086
0.8mm	5kg	200080
0.9mm	1kg	200076
0.9mm	15kg	200087
0.9mm	5kg	200081
1.2mm	15kg	200089

Disclaimer: The above information is provided as a guide; actual welding current and voltage will depend on the welding machine characteristics, which will vary from model to model. Other variables include run length and size, plate thickness, operator technique and gas type (if used). The user must evaluate the process, application and recommended professional advice. Under no circumstance will Dynaweld or its affiliates be liable for misuse or application of products this is entirely up to the user's ability.