

Filler rod and wire

Features: • Suitable for low carbon 18%Cr-12%Ni-2%Mo steel

Classification: AWS A5.9 ER316L

Shielding gas: Ar

Identification color: 1st Green

Polarity: DCEN

Packaging data

φ mm	Spool	Tube		
	kg	kg	Length mm	g/piece
0.8	10	5	1,000	4
1.0	10	5	1,000	6
1.2	10	5	1,000	9
1.6	10	5	1,000	16
2.0	-	5	1,000	25
2.4	-	5	1,000	36
3.2	-	5	1,000	64
Volume mm	240W, 110H, 240L		40W, 35H, 1015L	

Composition (rod and wire mass%)

	Typical	Guaranty ^a
C	0.01	0.03
Si	0.40	0.30~0.65
Mn	1.7	1.0~2.5
P	0.02	0.03
S	<0.01	0.03
Ni	12.0	11.0~14.0
Cr	18.7	18.0~20.0
Mo	2.2	2.0~3.0
Cu	0.11	0.75

Note: ^a Single values are maximum.

Welding parameters (A)

φ mm	
0.8	50~80
1.0	50~80
1.2	50~100
1.6	100~200
2.0	100~200
2.4	150~250
3.2	200~300

Approvals

All-weld mechanical properties

	Typical
0.2%YS (MPa)	390
TS (MPa)	550
El on 4d (%)	43
IV -196°C (J)	49

ABS	AWS A5.9 ER316L
LR	MG
DNV	NV316L, MG
BV	316LBT
NK	KY316L
GL	4435
CCS	AS-1B