

# Gas Tungsten Arc Welding

JIS Z3321 Y316L  
 AWS A5.9 ER316L  
 DIN 8556-SG 1.4430

## MS T-316L Filler Rod for Stainless Steel

**Applications** Suitable for welding of extra-low carbon 18%Cr-12%Ni-2%Mo stainless steel. In this filler metal reduces the possibility of intergranular chromium carbide precipitation

Brand Name		MS T-316L								
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0	
Representative of length	1000 mm Standard or 950 mm Upon requested									
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-	
	≤ 0.030	≤ 0.65	1.0-2.5	≤ 0.03	≤ 0.03	11.0-14.0	18.0-20.0	2.0-3.0	-	
Mechanical property of deposited metal										
Tensile strength	≥ 500 N/mm <sup>2</sup>									
0.2% Offset strength	≥ 205 N/mm <sup>2</sup>									
Elongation	≥ 35 %									
Impact test	2mm Vnotch Impact value at -196° C 39 J									
Welding position	All position									
Welding polarity	DC-EN									
Shielding gas	Ar									
Welding current	Dia. 1.2 mm		Dia. 1.6 mm			Dia. 2.4 mm				
	30-80 A		40-120 A			50-150 A				
Packing										
Inner case weight (kg)	5.00									