

Gas Tungsten Arc Welding

JIS -
AWS A5.9 ER316LSi
DIN 8556-SG 1.4430

MS T-316LSi Filler Rod for Stainless Steel

Applications Suitable for welding of extra-low carbon 18%Cr-12%Ni-2%Mo stainless steel. Usage as MS M-316L, but the 0.65-1.0% silicon content improves wetting behavior in the gas shielded welding process.

Brand Name		MS T-316LSi							
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	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 ²								
0.2% Offset strength	≥ 205 N/mm ²								
Elongation	≥ 35 %								
Impact test	NA								
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								