

CODIFICATION: AWS/SFA 5.9: ER316L

CHARACTERISTICS AND APPLICATIONS:

FW 316L is a solid wire for TIG welding, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality weld deposit. The weld metal has excellent resistance to intergranular corrosion even at elevated temperatures. It is ideal for welding stainless steel of similar composition in wrought or cast form and for overlay application to resist heat and corrosion. It is suitable for number of industries like rayon, dye, paper, chemical, fertilizer, petrochemicals, etc.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

| Element | C | Mn | Si | S | P | Cr | Ni | Mo |
|---------|------|------|------|-------|-------|------|------|-----|
| Percent | 0.02 | 1.50 | 0.50 | 0.010 | 0.020 | 19.0 | 12.5 | 2.5 |

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

| UTS (MPa) | Elongation (L=4d) % |
|-----------|---------------------|
| 520 | 32.0 |

SHIELDING GAS : Argon

CURRENT CONDITIONS : DCEN

WELDING POSITION : H, F, VU, OH

PACKING:

| | |
|----------------------|--|
| STANDARD SIZE | Diameter 1.6 mm 2.0 mm, 2.50 mm & 3.20 mm in cut lengths of 1000 mm each. |
| QUANTITY | 5 kgs wire put in an air-tight polythene bag and finally packed in a plastic container. Identification – AWS code is punched on both the sides of wire. |

An ISO 9001: 2008 certified company

D & H Sécheron Electrodes Pvt. Ltd.

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