

### Standards

|                   |                 |
|-------------------|-----------------|
| TS EN ISO 14343-A | : W Z 19 12 3 L |
| EN ISO 14343-A    | : W Z 19 12 3 L |
| AWS A5.9          | : ER 316 L      |

### Chemical Composition of Welding Wire % (Typical)

| C    | Si  | Mn  | Mo  | Cr   | Ni   |
|------|-----|-----|-----|------|------|
| 0.02 | 0.5 | 1.6 | 2.2 | 18.5 | 11.5 |

### Mechanical Properties

| Yield Strength<br>(N/mm <sup>2</sup> ) | Tensile Strength<br>(N/mm <sup>2</sup> ) | Impact Strength<br>(ISO-V/+20°C) | Elongation<br>(L <sub>0</sub> =5d <sub>0</sub> ) (%) |
|----------------------------------------|------------------------------------------|----------------------------------|------------------------------------------------------|
| min. 420                               | 570 - 700                                | min. 63 J                        | min. 30                                              |

### Typical Base Material Grades

- X2 CrNiMo 1814 3, XS CrNiMo 1713 3, X2 CrNiMo 1713 2, XS CrNiMoTi 1712 2, X6 CrNiMoTi 1712 2, X6 CrNiMoNb 1712 2, X2 CrNiMoN 1713 3, X2 CrNiMoN 1712 2
- AISI: 316, 316L, 316Cb, 316Ti

### Features and Applications

- TIG welding of 13% Cr ferritic stainless steels, high-carbon or stabilized steels of type 316, low-carbon stainless steels of type 316 L, all of which are used in machinery and equipment parts at production plants for food, chemical, drug textile and similar kinds of industries
- As shielding gas, Argon (Ar) is used
- Maintenance of resistance to intergranular corrosion at temperature values up to 400°C.
- Resistance to low temperatures varying at values down to -196°C

### Welding Positions



### Current Type

TIG D.C.(-)

### Operating Data

| Product Code | Diameter x Length<br>(mm) / (inch) |              | Weight<br>(Kg) | Package Type |
|--------------|------------------------------------|--------------|----------------|--------------|
| 6011100169   | 1,00 x 1000                        | 0.040" x 39" | 5              | Plastic Box  |
| 6011100399   | 1,20 x 1000                        | 0.047" x 39" | 5              | Plastic Box  |
| 6011100351   | 1,60 x 1000                        | 1/16 x 39"   | 5              | Plastic Box  |
| 6011100400   | 2,00 x 1000                        | 5/64 x 39"   | 5              | Plastic Box  |
| 6011100352   | 2,40 x 1000                        | 3/32 x 39"   | 5              | Plastic Box  |

Approvals: CCE, SEPRO, TL, RINA, DNV