

Standards

TS EN ISO 14343-A	: W Z 19 12 3 L
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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 (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation ((L ₀ =5d ₀) (%))
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 valves 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 (mm) / (inch)		Weight (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: CE, SEPRO, TL, DNV-GL, NK, RINA