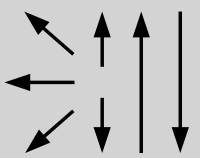


Classifications						
EN ISO 14343-A	EN ISO 14343-B		AWS A5.9			
G 19 12 3 L Si	SS316LSi		ER316LSi			
Characteristics and typical fields of application						
GMAW solid wire of type G 19 12 3 L Si / ER316LSi designed for first class welding, good wetting and feeding characteristics as well as reliable corrosion resistance up to +400 °C. Low temperature service down to -196 °C.						
Base materials						
1.4401 X5CrNiMo17-12-2, 1.4404 X2CrNiMo17-12-2, 1.4435 X2CrNiMo18-14-3, 1.4436 X3CrNiMo17-13-3, 1.4571 X6CrNiMoTi17-12-2, 1.4580 X6CrNiMoNb17-12-2, 1.4583 X10CrNiMoNb18-12, 1.4409 GX2CrNiMo19-11-2 UNS S31603, S31653; AISI 316L, 316Ti, 316Cb						
Typical analysis of solid wire (wt.-%)						
	C	Si	Mn	Cr	Ni	Mo
wt.-%	0.02	0.8	1.7	18.4	12.4	2.8
Mechanical properties of all-weld metal						
Condition	Yield strength R _{p0,2}	Tensile strength R _m	Elongation (L ₀ =5d ₀)	Impact work ISO-V KV J		
	MPa	MPa	%	+20 °C	-196 °C	
u	430 (≥ 320)	580 (≥ 510)	38 (≥ 25)	120	≥ 32	
u untreated, as welded – shielding gas Ar + 2.5 % CO ₂						
Operating data						
	Polarity: DC (+)	Shielding gases: Argon + max. 2.5 % CO ₂			ø (mm) 0.8 1.0 1.2	
Approvals						
TÜV (03233.), DB (43.014.11), DNV (316L), GL (4429S), Statoil, SEPROZ, CE						

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