

RAAJMIG ER 316L

Stainless steel continuous & cut length solid welding wire for MIG/TIG welding

CLASSIFICATION : AWS/SFA-5.9: ER316L, EN 12072 19.12.2L
DIN 8556: WK. 1.4430

CHARACTERISTICS : ER316L is austenitic Stainless steel low carbon welding wire of 18 Cr%, 12 Ni% and 2 Mo%. The weld metal contains ferrite and resistance to crack is extremely good. Low carbon assists austenitic arc stability and improves corrosion resistance such as intergranular type. The mechanical properties of the weld metal are good.

APPLICATION : ER 316L molybdenum type grade for the MIG, TIG and SA welding of similar type stainless steels. The molybdenum vastly improves the resistance of pitting corrosion, particularly in chloride solutions and the low carbon grades further improves resistance to intergranular corrosion. Suitable for welding SS 316L, SS 318 grades. The weld metal is recommended for high temperature service up to 350°C

SHIELDING GAS : welding with 100% Ar gas Or Ar+2%O₂ gas.

CHEMICAL COMPOSITION % (solid wire chemistry)

C	Mn	Si	S	P	Ni
0.030 max.	1.00-2.50	0.30-0.65	0.030 Max	0.030 Max	11.00-14.00
Cr	Mo	Cu			
18.00-20.00	2.00-3.00	0.75 Max			

ALL WELD MECHANICAL PROPERTIES (UNDER Ar GAS SHIELD)

UTS (N/mm ²)	Proof strength (N/mm ²)	EL % (5d)	CHARPY "V" NOTCH IMPACT AT	FERRITE Qty.(FN)
550-680	390-480	30-40	+20°C : 80-120 J -196°C : 50-70 J	7-9

DIEMENSION, CURRENT CONDITION & PACKING DATA (RAAJMIGER316L)

Size(mm)	Size(inch)	Current Condition (DC+)	Voltage (V)	Gas Flow Rate L/min.	Spool packing 12.5 kg.	Spool packing 15 kg	Drum packing 100/200kg
0.80	0.031	70-220	16-24	10-20	√	√	X
1.20	0.047	150-300	24-34	15-25	√	√	√
1.60	1/16"	150-350	28-36	15-30	√	√	√

DIEMENSION, CURRENT CONDITION & PACKING DATA (RAAJTIGER316L)

Size(mm)	Size(inch)	Length (mm)	Length (inch)	Current Condition (DC+)	Voltage (V)	Tube packing 5 kg	Box packing 20 kg
1.60	1/16"	1000	36"	40-80	10-16	√	√
2.0	5/64"	1000	36"	50-100	12-18	√	√
2.4/2.5	3/32"	1000	36"	60-120	14-20	√	√
3.2	1/8"	1000	36"	100-150	16-24	√	√
4.0	5/32	1000	36"	140-200	18-28	√	√

Raajratna offer a wide range of Stainless steel welding wires for MIG/TIG/SA welding.

And also available RAAJMIGER316LSi version for MIG welding process

Customer packing on request.



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