

SUBARC 316L



These consumables are used for Mo bearing austenitic stainless steels with 1.5-3% Mo. They are also suitable for Ti or Nb stabilised and nitrogen-bearing or free machining versions of the above alloys. Type 316/316L steels are widely used for their good resistance to pitting, many acids and general corrosion.

CLASSIFICATIONS

AWS	A5.9	ER316L
BS	EN 12072	19 12 3 L
DIN	8556	SG X2CrNiMo 19 12 (1.4430)

CHEMICAL ANALYSIS

% Carbon	0.010	% Chromium	18.50
% Manganese	1.400	% Nickel	12.80
% Silicon	0.500	% Molybdenum	2.600
% Sulphur	0.010	% Copper	0.150
% Phosphorus	0.015	% Ferrite	6.000

**TYPICAL MECHANICAL PROPERTIES
ALL WELD METAL**

Tensile Strength	570 MPa
0.2% Proof Stress	450 MPa
Elongation on 4d	41%
Impact Energy -196°C	30J

Microstructure

Austenite with a controlled level of ferrite, normally in the range 2-10FN depending on the application.

* Flux Dependant

PACKING DATA

SAW Wire (DC+)

Diameter (mm)	Current		Item Number	Pack Mass (Kg)
	Amps	Volts		
2.40	350	28	078-162	25
3.20	400	32	078-164	25
4.00	450	33	078-166	25

Suggested flux : Afrox Flux MH 01 or DX-9

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For more information contact the Afrox Customer Service Centre,
tel: 0860 020202 or e-mail: customer.service@afrox.boc.com
Website: www.afrox.com

