

TIG 316L



TIG 316 L consumables are used for Mo bearing austenitic Stainless Steels with 1.5-3% Mo. 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	0.03 max.	% Chromium	18.0 - 20.0
% Manganese	1.00 - 2.50	% Nickel	11.0 - 14.0
% Silicon	0.30 - 0.65	% Molybdenum	2.00 - 3.00
% Sulphur	0.03 max.	% Ferrite	6 - 12
% Phosphorus	0.03 max.		

**TYPICAL MECHANICAL PROPERTIES
ALL WELD METAL**

	TIG
Tensile Strength	550 - 700 MPa
0.2% Proof Stress	380 MPa min.
Elongation on 4d	35% min.
Impact Energy -130°C	50J min.

Microstructure
Austenite with a controlled level of ferrite, normally in the range 6-12FN depending on the application.

PACKING DATA

TIG (DC-)

Diameter (mm)	Current		Item Number	Pack Mass (Kg)
	Amps	Volts		
1.60	100	12	030-550	5
2.40	100	12	030-551	5

Suggested gas for welding : Argon (TIG)

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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

