



PRODUCT DATA SHEET

STAINLESS STEEL WIRE

316LSI



SUMMARY

- > Shielding Gas - Argon/CO₂* or Argon/ Oxygen 2%
- > Polarity - DC +

CLASSIFICATION

- > AS/NZS ISO 14343-BSS316LSi
- > AWS A5.9: ER316LSi

DESCRIPTION AND APPLICATION

Precision layer wound stainless steel welding wire depositing 19Cr/12Ni/2.5Mo extra low carbon type weld metal. For welding 316 and 316L plates, forgings, pipes, castings and bars in critical applications.

Also suitable for general purpose welding of common stainless steels such as 301, 302, 304 and 304L. Suitable for joining 316, 316L grades. Suitable for 301, 302, 304, 304L stainless steels.

OPERATIONAL DATA

Welding parameters shown below are for DC Electrode negative only.

WIRE SIZE (MM)	WELDING CURRENT RANGE (A)	ARC VOLT. RANGE *(V)
0.8	60 - 150	16 - 20
0.9	70 - 200	16 - 24
1.0	70 - 200	16 - 24
1.2	150 - 280	18 - 28

Welding Current DC -

*Voltage is determined by arc current and wire arc length.

Welding currents and voltage shown are operational guides only.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo
0.01	1.50	0.92	18.60	11.60	2.60

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Tensile Strength	600 MPa
Elongation	38%

PACKAGING DATA

WIRE SIZE (MM)	PACK SIZE AND TYPE	PART NO.
0.8	5kg spool	MIGSS316LSI085V
0.9	5kg spool	MIGSS316LSI095V
0.9	15kg spool	MIGSS316LSI09V
1.0	15kg spool	MIGSS316LSI10V
1.2	15kg spool	MIGSS316LSI12V

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Issue CA - May 2019