



Changzhou Giant Welding Co.,Ltd
www.giantweld.com

Standard: AWS A 5.9 YB/T5092	Chemical Composition %								
	C	Mn	Si	Cr	Ni	P	S	Mo	Cu
Grade ER316L	≤ 0.03	1.0–2.5	0.3 – 0.65	18 – 20	11 – 14	≤0.03	≤0.03	2 – 3	≤0.75
Type	Spool (MIG)				Tube (TIG)				
Specification (MM)	0.8、 0.9、 1.0、 1.2、 1.6、 2.0				1.6、 2.0、 2.4、 3.2、 4.0、 5.0				
Package	S100/1kg S200/5kg S270,S300/15kg-20kg				5kg/box	10kg/box	length :1000MM		
Mechanical Properties	Tensile Strength Mpa				Elongation after fracture A (%)				
	≥ 490				≥ 30				
Diameter (MM)	0.8	1.0	1.2	1.6	2.0	2.5	3.2		
Current (A)	70 ~ 150	100 ~ 200	140 ~ 220	50 ~ 100	100 ~ 200	200 ~ 300	300 ~ 400		
Application	ER316L is also called H03Cr19Ni12Mo2Si stainless steel wire. The weld metal is austenitic structure containing 19Cr-12Ni-Mo, which has good corrosion resistance, heat resistance and crack resistance because of the good corrosion resistance of Mo to acetic acid, sulfurous acid, phosphoric acid and salts. In particular, resistance to chloride pitting is beneficial. Mainly used in the welding of stainless steel in chemical industry,such as AIS316、 SUS316. It can also be used for welding of high chromium steel and dissimilar steel without heat treatment after welding. The welding of 18Cr-12Ni-Mo2 ultra-low carbon stainless steel has good welding process and good resistance to intergranular corrosion.								
Notice	1. Oil, dirt and rust on the welding wire surface should be removed before welding. Surface impurities such as oil, rust and water should be thoroughly removed in the welding place, so as to prevent blowhole, crack and so on during welding. The surface of the groove and its surroundings should be polished with metallic gloss. 2. In order to obtain good mechanical properties of welding seam, suggest protect gas Ar+2%O2 and shield gas flow rate 20-25 L/min for MIG welding. For TIG welding,suggest protect gas pure Ar and shield gas flow rate 8-15 L/min ,Arc length 1~3 mm; Length of the tungsten pole is about 3~5 mm; wind speed limit ≤ 1.0 m/s, argon protection at the back of welding area . 3. In the welding process, the welding line energy directly affects the mechanical properties and crack resistance of weld metal, and should be paid more attention to. 4. The above welding methods, conditions and specifications are for reference only. Users should evaluate the welding process according to their own welding characteristics before using the welding wire for the formal product welding.								

