TIG Consumables

T-316L

For austenite stainless steel (Dissimilar steels)

KISWEL

Classifications	
EN ISO 14343-A:2009	: W 19 12 3 L
EN ISO 14343-B:2009	: SS 316L
AWS A5.9-2012	: ER316L
KS D 3696:2006	: STSY316L
JIS Z 3321:2008	: Y316L

Approvals – I1 (100% Ar)	
ABS	: ER316L
BV	: T-316L
DNV	: NV 316L
LR	: 316Lm
KR	: RY316LG(I)
NK	: KY316L
RS	: A-5
Other	: TUV

Description

- TIG welding of 18%Cr-12%Ni-2%Mo austenite stainless steels (AISI STS 316, 316L)
- Various applications of petrochemical plant, fiber and paper industrial apparatus
- WRC 1992 FN 3-8 (Chemical composition of wire)

Polarity & shielding gas

- DCEN (DC-)
- Ar: 100% Ar (15 – 25 l/min)

Typical chemical composition of all-weld metal (%)

C	Si	Mn	Ni	Cr	Mo
0.02	0.40	1.73	11.71	18.15	2.22

Typical mechanical properties of all-weld metal

	Yield Strength	Tensile Strength	Elongation	Impact Value (J)	
	(MPa)	(MPa)	(%)	0 °C	-196 °C
AWS A5.9		Min. 490	Min. 30		
EN ISO 14343	Min. 320	Min. 510	Min. 25		
Example	430	560	40	150	45