



Cromatig 316LSi

GTAW - TIG
Stainless Steel

Date: 11/16/2014
Revision: 15

Description:

Cromatig 316LSi is primarily intended for welding the low carbon, molybdenum alloyed, acid resisting 316L austenitic stainless steels of similar composition. It is also suitable for grade 316 material and the Nb or Ti stabilised grades 347 and 321, provided service temperatures for structural work are below 350 °C. The higher silicon content provides a more fluid weld pool which may be preferred for certain welding applications.

Welding current:

DC-

Wire composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,65	1,0			18,0	11,0
Typical	0,015	0,85	1,75	0,015	0,01	18,5	12,0
Max	0,030	1,00	2,5	0,03	0,020	20,0	14,0

	Mo	Cu	N
Min	2,0		
Typical	2,7	0,1	0,06
Max	3,0	0,3	

Shielding gas:

I1, 99.99% Ar, 6-12 l/min

Stamping

Elga, AWS, Wst, EN, Batch

Ferrite content:

FN 8

Corrosion resistance

Good resistance to general and intergranular corrosion in the more severe environments e.g. hot dilute acids. Good resistance to chloride pitting corrosion.

Chemical composition, wt.%

	C	Si	Mn	Cr	Ni	Mo
Min						
Typical	0,015	0,8	1,7	18,0	12,0	2,6
Max						

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 350 MPa	400 MPa
Tensile Strength, Rm:	≥ 520 MPa	600 MPa
Elongation, A5	≥ 30%	40%
Impact energy, CV:		20 °C • 120 J -196 °C • 50 J

Classification:

EN ISO 14343 W 19 12 3 LSi
AWS A5.9 ER316LSi

Approvals:

DB 43.042.22
TÜV
DNV 316L
CE

Product data:

Ø x Length mm	Packet weight	Product code
1,0 x 1000	5 kg	98101010
1,2 x 1000	5 kg	98101012
1,6 x 1000	5 kg	98101016
2,0 x 1000	5 kg	98101020
2,4 x 1000	5 kg	98101024
3,2 x 1000	5 kg	98101032
1,6 x 500	4 x 1 kg	98101516
2,0 x 500	4 x 1 kg	98101520
2,4 x 500	4 x 1 kg	98101524

Note

All 500 mm rods are colour coded