



Cromamig 316L

GMAW - MIG MAG
Stainless Steel

Date: 2008-01-09
Revision: 8

Description:

Cromamig 316L is primarily intended for welding the low carbon, molybdenum alloyed, acid resisting 316L austenitic stainless steels of similar composition. Suitable also for welding normal carbon 316 grades and Nb or Ti stabilised steels provided service temperatures are below 400°C.

Welding current:

DC+

Wire composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,30	1,0			18,0	11,0
Typical	0,015	0,4	1,7	0,020	0,010	18,5	12,0
Max	0,030	0,65	2,5	0,030	0,020	20,0	14,0

	Mo	Cu	N
Min	2,0		
Typical	2,6	0,10	0,06
Max	3,0	0,75	

Shielding gas:

Acc. to EN 439:

M12, Ar + 2% CO₂, 16-21 l/min

M13, Ar + 1-3% O₂, 16-21 l/min

Ferrite content:

FN 5

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	P	S	Cr	Ni
Min							
Typical	0,015	0,4	1,7	0,02	0,01	18,5	12,0
Max							

	Mo	Cu	N
Min			
Typical	2,6	0,10	0,06
Max			

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 350 MPa	420 MPa
Tensile Strength, Rm:	≥ 520 MPa	600 MPa
Elongation, A5	≥ 30%	35%
Impact energy, CV:		20°C • 100 J -196°C • 50 J

Classification:

EN ISO 14343

AWS A5.9

G 19 12 3 L

ER316 L

Approvals:

CE

Product data

Diam.mm	Product code	Dip Current A	Dip Voltage V	Spray Current A	Spray Voltage V
0,8	9811-2008	60-100	18-21	150-170	24-26
1,0	9811-2010	75-140	18-21	170-200	26-28
1,2	9811-2012	130-160	18-21	175-250	26-28