



AWS A5.9 ER316L  
JIS Z3321 Y316L

**Characteristics:**

It is austenitic stainless steel filler metal for welding of 18%Cr-12%Ni-2%Mo types. The molybdenum increased pitting corrosion resistance. The low carbon content improved intergranular corrosion.

**Applications:**

Typical applications include welding of 18%Cr-12%Ni-2%Mo stainless steel in chemical, oil and gas refineries.

**Notes on Usage:**

1. For TIG process, use DC(-) current, Argo Shield and Tungsten Electrode.
2. For MIG process, use Spray Transfer or Short Circuit Transfer mode.
3. 98%Argon – 2%O<sub>2</sub> shielding gas is recommended in MIG process.

**Typical chemical composition of weld metal (wt%)**

C	Cr	Ni	Mo	Mn	Si
0.023	19.60	13.1	2.30	1.45	0.50

**Typical mechanical properties of weld metal**

TS N/mm <sup>2</sup>	EL %
580	40

**Sizes available**

MIG Solid Wire(mm)	0.8	0.9	1.0	1.2
TIG Rods(mm)	1.6	2.0	2.4	3.2