

Filler rod and wire

Features:	▪ Suitable for 18%Cr-12%Ni-2%Mo steel
Classification:	AWS A5.9 ER316
Shielding gas:	Ar
Identification color:	1st White
Polarity:	DCEN

Packaging data

φ mm	Spool		Tube	
	kg	kg	Length mm	g/piece
1.0	10	5	1,000	6
1.2	10	5	1,000	9
1.6	10	5	1,000	16
2.0	-	5	1,000	25
2.4	-	5	1,000	36
3.2	-	5	1,000	64
Volume mm	240W, 110H, 240L		40W, 35H, 1015L	

Composition (rod and wire mass%)

	Typical	Guaranty ^a
C	0.04	0.08
Si	0.47	0.30~0.65
Mn	1.5	1.0~2.5
P	0.03	0.03
S	<0.01	0.03
Ni	12.0	11.0~14.0
Cr	19.1	18.0~20.0
Mo	2.1	2.0~3.0
Cu	0.26	0.75

Note: ^a Single values are maximum.

Welding parameters (A)

φ mm	
1.0	50~80
1.2	50~100
1.6	100~200
2.0	100~200
2.4	150~250
3.2	200~300

All-weld mechanical properties

	Typical
0.2%YS (MPa)	390
TS (MPa)	570
EI on 4d (%)	42
IV 0°C (J)	110