

316H

CATEGORY	GMAW-GTAW Solid wires																																
TYPE	Solid stainless steel welding wire with high carbon content																																
APPLICATIONS	Used for welding steam piping, superheater headers, furnace parts, some gas and steam engine turbine components, in the petro-chemical industry, in fossil and nuclear fuelled power stations.																																
PROPERTIES	316H is designed for welding 316/316H austenitic stainless steels operating at high temperatures (500-800°C) under long term creep conditions. This filler metal can also be used for welding 321/321H and 347/347H grades in high temperature structural service. This is particularly important in thick highly restrained weldments, since the possibility of premature service failure by intergranular HAZ cracking is reduced by using more ductile weld metal rather than 347H.																																
CLASSIFICATION	AWS	A 5.9: ER 316H																															
	EN ISO	14343-A: G 19 12 3 H 14343-B: SS 316H																															
	DIN: W.Nr.	1.4403																															
	DIN	8556: ~SG X5CrNiMo 19 11																															
SUITABLE FOR	AISI 316, 316H, 347, 347H, 321, 321H, CF10M, BS 316S51, 316S52, 316S53, 316C16, 316C71, UNS S31609																																
APPROVALS	CE approved																																
WELDING POSITIONS:																																	
ALL-WELD METAL ANALYSES	<table border="1"> <thead> <tr> <th>C</th> <th>Mn</th> <th>Si</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Cu</th> <th>P</th> <th>S</th> <th>FN</th> </tr> </thead> <tbody> <tr> <td>0.04-0.08</td> <td>1.0-2.5</td> <td>0.30-0.65</td> <td>18-20</td> <td>11-14</td> <td>2-3</td> <td><0.3</td> <td><0.03</td> <td><0.02</td> <td>3-8</td> </tr> </tbody> </table>									C	Mn	Si	Cr	Ni	Mo	Cu	P	S	FN	0.04-0.08	1.0-2.5	0.30-0.65	18-20	11-14	2-3	<0.3	<0.03	<0.02	3-8				
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GAS ACC. EN ISO 14175:	M11, M12, M13																																