

Stainless Steel MIG•TIG Wire/Rod

GM316 / GT316

AWS A5.9 ER316
JIS Z 3321 YS316
ISO 14343-B-SS316

Product Features:

- Austenite structure weld metal, good of heat, corrosion and crack resistance.
- Weld metal contains Mo element to get good inter-granular crevice corrosion resistance.

Applications:

- Suitable for welding of severe acid and high heat resistance required SUS316 stainless steel.

Shielding gas:

- Ar+ 1~2% O₂ (MIG)
- 100%Ar (TIG)

Typical chemical composition of wire / rod (wt%)

C	Si	Mn	Ni	Cr	Mo	Fe
0.04	0.40	1.48	13.5	18.8	2.7	Bal.

Typical mechanical properties of all weld metal

Tensile Strength N/mm ²	Elongation %
580	38

MIG Size (mm) & recommended welding parameters; DC+

Diameter (mm)	0.9/1.0	1.2	1.6
Current range (Amp)	70~200	90~250	200~300

TIG rod size diameter/length; DC-

Diameter (mm)	1.6	2.0	2.4/2.6	3.2
Length (mm)	1000	1000	1000	1000

Note:

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