

Stainless Steel MIG•TIG Wire/Rod

GM316L / GT316L

AWS A5.9 ER316L
JIS Z 3321 YS316L
ISO 14343-A-G 19 12 3 L
14343-A-W 19 12 3 L

Product Features:

- Austenite structure weld metal, good heat, corrosion and crack resistance, better inter-granular corrosion resistance than 316.
- 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
0.012	0.60	1.53	11.50	18.52	2.53	Bal.

Typical mechanical properties of all weld metal

Tensile Strength N/mm ²	Elongation %	Impact value (-196°C) J
639	44	80

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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