



ER316L

Certifications:

AWS A5.9
ASME SFA 5.9

Features

- Improved pitting corrosion resistance of the weld deposit.
- Can be used for high temperature service applications.

Applications

- Primarily used for welding low carbon molybdenum bearing austenitic alloys.
- Used for high pressure piping and tubing.

Diameters & Packages

Diameter	2 lb	10 lb	12.5 lb	25 lb	30 lb	33 lb	55 lb	60 lb	330 lb	36"
0.023	✓	✓			✓					✓
0.025		✓								
0.030	✓	✓		✓	✓	✓				✓
0.035	✓	✓		✓	✓					✓
0.045		✓	✓		✓	✓				✓
1/8							✓		✓	✓
1/16					✓			✓	✓	✓
3/16										✓
3/32								✓	✓	✓
5/32								✓		✓
5/64								✓		

Technical Specifications

Shielding Gas: 100% Argon

Typical Chemical Composition:

Chemical	C	Cr	Ni	Mo
%	0.015	18.75	12.25	2.50

Chemical	Mn	Si	P	S
%	1.80	0.34	0.010	0.010

Recommended Weld Parameters (MIG):

Short Arc Welding			
Diameter	Wire Feed	Amps	Volts
0.030	13-26	40-120	16-20
0.035	13-26	60-140	16-22

Spray Arc Welding

Diameter	Wire Feed	Amps	Volts
0.035	20-39	140-220	24-29
0.045	16-30	160-260	25-30
1/16	10-16	230-350	27-31

Recommended Weld Parameters (SAW):

Diameter	Amps	Volts
3/32	250-450	28-32
1/8	300-500	39-34
5/32	400-600	30-35
3/16	500-700	30-35

Typical Mechanical Properties

Yield Strength	Tensile Strength	Elongation
59,000 psi	88,000 psi	35%