



Nevatia Steel & Alloys Pvt. Ltd.
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Web: <http://www.nevatiasteel.com>



TD-Stainless Welding wire
Revision No.: 02
Date of Issue : 01.11.2019

IATF 16949, ISO 9001, ISO 14000 and ISO 45001 Certified Company

Stainless steel welding wire - Technical data

Product Name : nevinox[®]MIG316LSi

Product Specifications : ER 316LSi

Grade	Equivalent Standards		
	AWS A5.9/5.9M	EN ISO 14343 A	EN ISO 14343 B
ER 316LSi	ER 316LSi	19 12 3 L Si	316LSi

Characteristics : ER316LSi is austenitic Stainless steel low carbon welding wire of 18 Cr%, 12 Ni% and 2 Mo% With silicon content is high in wire compositions for better weld fluidity with fine rippled and shine weld bead appearance. The weld metal contains ferrite and resistance to crack is extremely good. Low carbon assists austenitic arc stability and improves corrosion resistance such as intergranular type.

Application : ER 316LSi molybdenum type grade for the MIG, TIG and SA welding of similar type stainless steels. The molybdenum vastly improves the resistance of pitting corrosion, particularly in chloride solutions and the low carbon grades further improves resistance to intergranular corrosion. Suitable for welding SS 316L, SS 318 grades. The weld metal is recommended for high temperature service up to 350^oC

Chemical Composition % (Solid wire)

C	Mn	P	S	Si	Cr	Ni	Mo	Cu
0.03	1.30 - 2.10	0.030	0.020	0.65 - 1.00	18.00 - 20.00	11.00 - 13.00	2.50-3.00	0.30

Remarks: Single values shown in the table are maximum values. Two values shown indicate minimum and maximum limits for a range.

Typical All weld Mechanical properties

Product	Grade	Shielding Gas	N/mm ²		% EL (GL=50mm)	Impact Value (Joules)			
			YS (0.2% PT)	TS		-20 ^o C	-60 ^o C	-101 ^o C	-196 ^o C
MIG	ER 316LSi	M12	439	630	37	-	-	-	63
MIG	ER 316LSi	M21	431	606	34				90

Current Conditions:- DC (+)



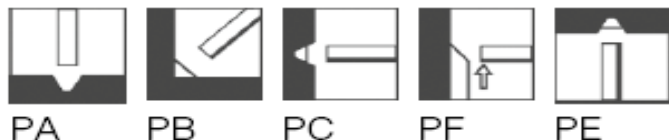
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Welding position:-



Dimension & Packing Data

Size(mm)	Size(inch)	SD100 Spool packing 1kg/2lb	SD200Spool packing 5kg/10lb	SD300/BS300 Spool packing 12.5kg,15kg /25lb, 33lb	Drum packing 100kg,250kg/ 200lb, -550 lb
0.600	0.024	√	√	-	-
0.800	0.030	√	√	√	√
0.900	0.035	√	√	√	√
1.000	0.040	√	√	√	√
1.200	0.045	√	√	√	√
1.600	0.063	-	√	√	√

Diameter tolerance and ovality

- As per AWS A5.9 and ISO 544

Inspection & certification

- As per EN 10204 type 3.1

Approvals :



For more details please contact : sales@nevatiasteel.com.