MIG 20/10M

Old reference: MIG 316L

Classification

ISO 14343-A : G 19 12 3 L
AWS A5.9 : ER316L

Material N° : 1.4430

Description & Applications

Low carbon solid wire for joining of stabilised stainless steels (316, 316L…) stabilised or not. Service temperature from -120℃ up to +400℃.

Main applications: Chemical and petrochemical industries, refineries, food industries…

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe
0.018	0.45	1.7	18.5	12.2	2.7	0.1	<0.02	<0.01	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
430	620	35	+20℃ 120 -196℃ 45

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters (A)	Welding parameters (V)	Shielding Gas
MIG = +	0.8 1.0 1.2 1.6	100-150 120-200 140-220 180-260	22-27 24-28 24-28 24-30	Ar + 2%CO_2 Ar + 1%O_2 18-20 l/min

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