SELECTARC MIG 316H

Classification

AWS A 5.9 : ER316H ISO 14343-A W 19 12 3 H

Characteristics

GMAW wire for Gas Tungsten Arc Welding with increased carbon and approx. 5% ferrite designed to weld 17/12/2 (316H) stainless steels as well as stabilized grades used for high temperature service up to 750°C.

Applications

Petrochemical industries, Tanks, Heat exchangers, Piping systems.

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe	FN
0.05	0.40	1.70	18.50	11.50	2.10	0.05	0.02	0.01	Base	~5

All Weld Metal Mechanical Properties(Typical, As Weld)

YS Rp0.2(MPa)	UTS Rm(MPa)	% Elg A5 (%)
390	585	31

Welding Parameters & Instructions

Welding Process	Ø of Wire (mm)	Welding Mode		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	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: 6-12 l/min Back Purging: Ar or N_2/H_2: 3 - 6 l/min

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