MIGINOX 316L / TIGINOX 316L

GMAW / GTAW
STAINLESS STEEL

19Cr/12Ni/Mo TYPE STAINLESS STEEL SOLID WIRE

CLASSIFICATION :	EN ISO 14343-A	AWS A/SFA 5.9	APPROVALS :
Miginox 316L:	G 19 12 3 L	ER316L	-
Tiginox 316L:	W 19 12 3 L	ER316L	IRS

KEY FEATURES :

- An extra low carbon 19Cr/12Ni/Mo type stainless steel wire
- Offers improved corrosion and pitting resistance in marine and industrial environment
- High resistance against intergranular corrosion
- Resistant to SCC, hot cracking and chemical attack upto 850°C
- Radiographic quality welds

WELDING POSITION :

GMAW: DCEP
GTAW: DCEN

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
GMAW: 98Ar/2O_2 or Ar/1-5CO_2	15-22	10-20
GTAW: Ar	10-15	-

TYPICAL APPLICATIONS :

- Welding austenitic alloys represented by AISI 316, 316L, 317, 317L, 318 types
- Joining similar grade wrought and cast material
- Application in textile processing, Naval and Chemical environments, Paper and pulp, Paint and dye industries
- Cladding stainless steels

STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

	C	Mn	Si	Cr	Ni	Mo	S	P
Specification	0.03 max	1.0-2.5	0.30-0.65	18.0-20.0	11.0-14.0	2.0-3.0	0.03 max	0.03 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%
Specification	As Welded	490 min	30 min

Mechanical properties will vary with the type of shielding gas used.

SPECIAL TEST:

IGC practice E and B as per ASTM A262

PACKING DATA :

	Ø, mm		Kg/Spool	
Miginox 316L	0.8		12.5	
	1.2		12.5	
	1.6		12.5	
	2.0		12.5	
Tiginox 316L	**Ø x L, mm**	**Primary Box, Kg**	**No. of Primary Boxes**	**Net Wt. of Carton, Kg**
	1.6 x 1000	5	4	20
	2.0 x 1000	5	4	20
	2.5 x 1000	5	4	20

EQUIVALENT :

SMAW Electrode: **Superinox 2C**

FCAW Wire: **Miginox FC 316L**