



Cromatig 316L

GTAW - TIG
Stainless Steel

Date: 2008-01-22
Revision: 9

Description:

Cromatig 316L is primarily intended for welding the low carbon, molybdenum alloyed, acid resisting 316L austenitic stainless steels of similar composition. Suitable also for welding 316 grades as well as Nb or Ti stabilised steels provided service temperatures for structural work are below 400°C.

Welding current:

DC-

Wire composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,30	1,0			18,0	11,0
Typical	0,015	0,40	1,7	0,020	0,010	18,5	12,0
Max	0,030	0,65	2,5	0,030	0,020	20,0	14,0

	Mo	Cu	N
Min	2,5		
Typical	2,6	0,10	0,06
Max	3,0	0,30	

Shielding gas:

Acc. to EN 439:

l1, 99.99% Ar, 6-12 l/min

Stamping

Elga, AWS, Wst, EN, Batch

Ferrite content:

FN 6

Corrosion resistance

Good resistance to general and intergranular corrosion in the more severe environments e.g. hot dilute acids. Good resistance to chloride pitting corrosion.

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min							
Typical	0,015	0,4	1,8	0,02	0,01	18,5	12,0
Max							

	Mo	Cu
Min		
Typical	2,7	0,10
Max		

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 350 MPa	400 MPa
Tensile Strength, Rm:	≥ 520 MPa	600 MPa
Elongation, A5	≥ 30%	40%
Impact energy, CV:		20°C • 150 J -196°C • 60 J

Classification:

EN ISO 14343

W 19 12 3 L

AWS A5.9

ER316L

Approvals:

DNV

CE

Product data

Diam.mm	Length mm	Product code
1,2	1000	9811-1012
1,6	1000	9811-1016
2,0	1000	9811-1020
2,4	1000	9811-1024
3,2	1000	9811-1032