



316LSi XM

AWS A 5.9: ER316LSi ISO 14343-A: G 19 12 3 LSi

DESCRIPTION

Low carbon austenitic stainless alloy with around 8% ferrite. Soft transfer, smooth bead. Fer welding of Cr-Ni-Mo stainless steels. Excellent for material with operating temperature between -120°C up to 400°C in chemical industry, petroleum, food and shipbuilding for welding of piping systems, tanks, heat exchangers etc. Higher Si content gives better weld metal flow and improves bead appearance.

WELDING POSITIONS



CURRENT

DC+

GAS

Ar / Co₂

BASE MATERIALS

Stainless and austenitic stainless steels

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A₅</i> (%)	<i>KV(j)</i>
630	440	37	+20°C – 120 -60°C – 95

WELD METAL COMPOSITION(%)

C	Mn	Si	Cr	Mo	Ni	
0,02	1,8	0,8	18,5	2,7	12,5	

PACKAGING

Dimension(mm)	0,6	0,8	1,0	1,2
Spool size(kg)	1/5/15	1/5/15/250	1/5/15/250	5/15/250
Wire feeding/min	3-7	3,4-11	2,9-8,4	4,9-8,5
Ampere (A)	50-140	50-140	80-190	180-280
Volt (V)	16-20	16-22	16-24	20-28

EQUIVALENT FILLER METALS

MMA	Meltolit 316L E /316L VD
TIG	Meltolit 316LSi XT
FCW	Meltolit 316L FCW/ 316L FCW-PW