

ELBOR STAINLESS STEEL AWS A 5.9 316 LSI

Austenitic stainless steel filler metal suitable for welding parent metals like AISI 316, AISI 316L. Equivalent to ER 316L except for higher Silicon content. This improves the arc stability, the weld metal fluidity and the melt run appearance. If the dilution by the parent metal produces a low ferrite or fully austenitic weld, the hot cracking sensitivity of the weld is higher than that of a lower Si content weld metal. Therefore it guarantees better corrosion resistance than ER 308LSi.

Solid wire, low carbon for welding stainless steel to 19% chromium, 12% nickel and 2-3% molybdenum, for temperatures up to 400 ° C. The high silicon content allows a good arc stability and achieve good weld appearance and splashing contents. Used in manufacture of tubes, plating, and in pressure vessels, shipbuilding and marine and saline environments. Good corrosion resistance in general and intergranular corrosion against acid substances. To be used under protective gas Ar (98%) O2 (2%)

NORM: EN ISO 14343-A: G 19 12 3 L Si - WERKSTOFF. 1.4430

MATERIAL TO BE WELD :

316 - 316 Cb - 316 L - 316 LN -316 Ti - CF3 M - CF8 M

EN CLASSIFICATION:

10088-1/-2 X2CrNiMo 17-12-2
10088-1/-2 X2CrNiMo 18-14-3
10088-1/-2 X2CrNiMoN 17-11-2
10088-1/-2 X2CrNiMoN 17-13-3
10088-1/-2 X4CrNiMo 17-12-2
10088-1/-2 X4CrNiMo 17-13-3
10088-1/-2 X5CrNiMo 17-12-2
10213-4 GX5CrNiMo 19-11

TYPICAL CHEMICAL CONTENT / ANALISI CHIMICA TIPICA:

Mo	2.50 – 3.00
Cr	18.00-20.00
Ni	11.00-13.00
Mn	1.40-2.20
Si	0.65-1.00
Cu	0.30
C	0.03

AWS A 5.9: ER316LSi

EN ISO 14343-A: G 19 12 3 L Si

Elongation	34 %
Impact Strenght Kv (+20°C)	>47 J
Tensile Strenght	660 MPa
Yeld Strenght	480 MPa

Welding positions :



Tutte le posizioni