

RONOX-316L

STAINLESS STEEL CONTINUOUS & CUT LENGTH
SOLID WELDING WIRE FOR MIG/TIG WELDING

BASIC ALLOY: FE, CR, NI, MO
AWS/SFA-5.9: ER308L, BS 19.9.L3L
EN ISO 14343-A 19 9 3L

KEY FEATURES:

ER316L is austenitic Stainless steel low carbon welding wire of 18 Cr%, 12 Ni% and 2 Mo%. The weld metal contains ferrite and resistance to crack is extremely good. Low carbon assists austenitic arc stability and improves corrosion resistance such as intergranular type. The mechanical properties of the weld metal are good.

APPLICATIONS

- ER 316L molybdenum type grade for the MIG, TIG and SA welding of similar type stainless steels. The molybdenum vastly improves the resistance of pitting corrosion, particularly in chloride solutions and the low carbon grades further improves resistance to intergranular corrosion. Suitable for welding SS 316L, SS 318 grades. The weld metal is recommended for high temperature service up to 350C

SHEILDING GAS:

- welding with 100% Ar gas Or Ar+2%O₂ gas.

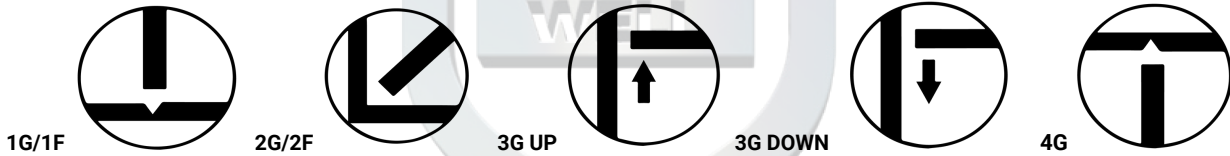
CHEMICAL COMPOSITION:

C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.030 max.	1.00-2.50	0.30-0.65	0.030 Max	0.030 Max	11.00-14.00	18.00-20.00	2.00-3.00	0.75 Max

MECHANICAL PROPERTIES:

UTS (N/mm)	Proof strength (N/mm ²)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT @	FERRITE Qty.(FN)
550-680	390-480	30-40	+20C : 80-120 J -196C : 50-70 J	7-9

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA (FOR MIG WELDING)

Size (mm)	Size (inch)	Current Condition (DC+)	Voltage (V)	Gas Flow Rate L/min	Spool packing 12.5 kg	Spool packing 15 kg	Drum packing 100/200kg
0.80	0.031	70-220	16-24	10-20	✓	✓	X
1.20	0.047	150-300	24-34	15-25	✓	✓	✓
1.60	1/16"	150-350	28-36	15-30	✓	✓	✓

DIEMENSION, CURRENT CONDITION & PACKING DATA (FOR TIG WELDING)

Size (mm)	Size (inch)	Length (mm)	Length (Inch)	Current Condition (DC+)	Voltage (V)	Tube packing 5 kg	Box packing 20 kg
1.60	1/16"	1000	36"	40-80	10-16	✓	✓
2.0	5/64"	1000	36"	50-100	12-18	✓	✓
2.4/ 2.5	3/32"	1000	36"	60-120	14-20	✓	✓
3.2	1/8"	1000	36"	100-150	16-24	✓	✓
4.0	5/32	1000	36"	140-200	18-28	✓	✓