

DATA SHEET N. S40 - 002**DAIKOWM 316LSi****MIG**

Description / Alloy type: Solid stainless wire for 316L Mo bearing austenitic stainless steels.

Specifications: **AWS A5.9** **EN ISO 14343-A**
ER316LSi 19 12 3 L Si

Approvals: TÜV (MIG); CE.

Applications: These consumables are used for Mo bearing austenitic stainless steels with 1.5 ÷ 3 Mo.

316 steels are used for their good resistance to pitting, many acids and general corrosion.

The higher silicon content (if compared with standard 316L) increase the welding fluidity and improve the bead appearance.

Materials to be welded: **ASTM:** 316L; 316, 316LN; CF3M; CF8M;
EN & DIN: 1.4404/1.4401; 1.4435/1.4436; 1.4406/1.4429; 1.4408; 1.4437.Composition:
(weight %)

%	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	FN
Min	-	1.0	0.65	-	-	18.0	11.0	2.5	-	3
Max	0.030	2.0	1.00	0.02	0.030	20.0	14.0	3.0	0.3	10
Typ	0.015	1.4	0.80	0.01	0.015	18.5	12.8	2.6	0.15	6

Typical parameters:

	MIG
Shielding	Ar + 2% O ₂ Ar-He + <3% CO ₂
Current	DC+
Diameter	1.2 mm
Parameters	260A, 26V

All-weld proprieties:

As welded	min	MIG
Tensile strength [MPa]	510	570
0.2% proof stress [MPa]	320	435
Elongation [%]	30	42
Impact Energy -196°C [J]	-	>30
Hardness HV	-	200/220

Complementary products: SMAW basic / rutile electrode (AWS A5.4 E316L-15/16/17)
FCAW wire 316L / 316LP (AWS A5.22 E316LT0-1/4 / E316LT1-1/4)
MIG, TIG & SAW WIRE (AWS A5.9 ER316L)
Strip (AWS A5.9 EQ316L)

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SEDI OPERATIVE

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