

316S92

MIG (GMAW)

SOLID WIRE FOR MIG

PRODUCT DESCRIPTION

Solid wire for MIG welding.

CLASSIFICATIONS

AWS A5.9M	ER316L
ISO 14343-A	G 19 12 3 L
ISO 14343-B	SS316L
Approvals	TÜV, LRS

ASME IX QUALIFICATION

QW432	F-No 6
QW442	A-No 8

CHEMICAL COMPOSITION (WIRE WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	FN
Min.	--	1.0	0.30	--	--	18.0	11.0	2.5	--	3
Max.	0.03	2.0	0.65	0.020	0.030	20.0	14.0	3.0	0.3	10
Typical	0.01	1.4	0.5	0.01	0.015	18.5	12.8	2.6	0.15	6

ALL-WELD MECHANICAL PROPERTIES

As welded	Min.	Typical
Tensile strength (MPa)	510	570
0.2% proof strength (MPa)	320	435
Elongation (%) 4d	30	42
5d	30	40
Impact ISO-V(I) -130°C	--	> 70
-196°C	--	30-60
Hardness cap/mid (HV)	--	200/220

* See data sheet B-38 for as-welded cryogenic applications at -196°C.

TYPICAL OPERATING PARAMETERS

Shielding gas	Current	Diameter (mm)	Parameters
Ar+2%O ₂ *	DC+	1.2	260A, 26V

* Also proprietary Ar and Ar-He gas mixtures with < 3%CO₂.

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
1.0	15	S300	M316S92-10
1.2	15	S300	M316S92-12

FUME DATA (WT % TYPICAL)

Fe	Mn	Cr ³	Ni	Mo	Cu	OES (mg/m ³)
30	12	15	11	1.5	< 0.5	3.3