



# Cromamig 316LSi

GMAW - MIG MAG  
Stainless Steel

Date: 06/09/2012  
Revision: 10

## Description:

Cromamig 316LSi is primarily intended for welding the low carbon, molybdenum alloyed, acid resisting 316L austenitic stainless steels of similar composition. Suitable also for welding 304L type steels as well as normal carbon 316 grades and Nb or Ti stabilised steels provided service temperatures are below 400°C. The higher silicon content gives better arc stability and weld metal flow which improves bead appearance, particularly when dip transfer welding.

## Welding current:

DC+

## Wire composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,65	1,0			18,0	11,0
Typical	0,015	0,85	1,75	0,015	0,01	18,5	12,0
Max	0,030	1,00	2,5	0,03	0,020	20,0	14,0

	Mo	Cu	N
Min	2,5		
Typical	2,7	0,1	0,06
Max	3,0	0,3	

## Shielding gas:

M12, Ar + 2% CO<sub>2</sub>, 16-21 l/min

M13, Ar + 1-3% O<sub>2</sub>, 16-21 l/min

## Ferrite content:

FN 8

## Corrosion resistance

Good resistance to general and intergranular corrosion in the more severe environments e.g. hot dilute acids. Good resistance to chloride pitting corrosion.

## Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min							
Typical	0,015	0,8	1,7	0,015	0,01	18,0	12,0
Max							

	Mo
Min	
Typical	2,6
Max	

## Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 350 MPa	400 MPa
Tensile Strength, Rm:	≥ 520 MPa	600 MPa
Elongation, A5	≥ 30%	40%
Impact energy, CV:		20°C • 120 J -196°C • 50 J

## Classification:

EN ISO 14343

AWS A5.9

G 19 12 3 LSi

ER316LSi

## Approvals:

DB

TÜV

CE

Kennblatt Nr 43.042.22

**Product data:**

Diam.mm	Product code	Spool weight	Dip Current A	Dip Voltage V	Spray Current A	Spray Voltage V
0,8	98102008	15 kg S300	60-100	18-21	150-170	24-26
1,0	98102010	15 kg S300	75-140	18-21	150-170	26-28
1,2	98102012	15 kg S300	130-160	18-21	175-250	26-28
0,6	98103006	5 kg D200	50-80	18-21	140-170	24-26
0,8	98103008	5 kg D200	60-100	18-21	150-170	24-26
1,0	98103010	5 kg D200	75-140	18-21	150-170	26-28
1,0	98104010	220 kg AUTOPAC	75-140	18-21	150-170	26-28
1,2	98104012	220 kg AUTOPAC	130-160	18-21	175-250	26-28