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MIG AND TIG STAINLESS STEEL WIRES.

Swiss Alloys® 316LSi

SPECIFICATIONS

AWS 5.9
ASME SFA 5.9
EN ISO 14343 EN steel no 19 12 3 LSi

CLASSIFICATIONS

AWS ER316LSi
UNS S31688

DESCRIPTION / APPLICATION

Swiss Alloys ER316LSi is used for welding low carbon molybdenum-bearing austenitic alloys. This filler metal is similar to Swiss Alloy ER316L, with higher silicon content for optimum ease in welding and smooth bead appearance. Higher productivity could be realized in the MIG welding process.

Typical Chemical Analysis						
C	Mn	Si	Cr	Ni	Mo	S
0.03 max	1.0- 2.5	0.65- 1.00	18.0- 20.0	11.0- 14.0	2.0- 3.0	0.03 max
P	Cu					
0.03 max	0.75 max					

TYPICAL MECHANICAL PROPERTIES

Tensile strength: 86,500 psi 600 MPa
Yield strength: 58,500 psi 400 MPa
Elongation: 36%

Approvals CE, DB, TÜV

Typical Welding Parameters of Stainless steel wire			
Process	Diameter of Wire	Welding Voltage (V)	Welding Current (A)
TIG	0.80 mm	12 V - 15 V	60 A - 90A
	1.2 mm	13 V - 16 V	80 A - 110 A
	1.6 mm	14 V - 18 V	90 A - 130 A
	2.4 mm	15 V - 20 V	150 A - 220 A
	3.2 mm	15 V - 20 V	150 A - 220 A
MIG	1.0 mm	26 V - 29 V	150 A - 190 A
	1.2 mm	28 V - 32 V	180 A - 220 A
	1.6 mm	29 V - 33 V	200 A - 250 A