



# WB316LM M.I.G. WELDING WIRE

## Classifications

AWS A5.9 : ER316L (Si)

BSEN12072-00 : G19 12 3L (Si)

## Product Description

316L stainless steel, solid MIG wire.

## Applications

WB316LM is used mainly for welding and repairing 316L stainless steels and wrought and cast alloys 316, S62, CF3M, CF8M and 316C12 it is also suitable for the mixed welding of 304L, 316L, 321 and 347 stainless steels.  
Ferrite in the 3-10FN range.  
Corrosion resistant up to 400°C.

## Wire Composition(Weight %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
min.	-	1.0	0.30	-	-	18.0	11.0	2.0	-
max.	0.03	2.5	**1.00	0.03	0.03	20.0	14.0	3.0	0.50

## Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm <sup>2</sup>	510 min.
Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup>	320 min.
Elongation on 5D	%	25 min.
Impact Energy CV @ as-welded	Joules	-

\*\*meets L & Si grades

Wire Dia (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
min.		-	80	120	160	180	-	-
Current Range (Amps)	max.	-	180	240	260	300	-	-
min.		-	17	17	18	20	-	-
Volt Range (Volts)	max.	-	20	22	26	29	-	-

## Packaging Information

Kg Per Reel	-	0.7/15	15	15	15	-	-
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## Storage

### Storage

It is recommended that the WB range of wires are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%.

## Gases

### Gas

Pure Argon or Argon + 2%O<sub>2</sub> mixture

### Flow Rate

12-16 l/min

## Current Conditions DC+ and Welding Positions

