



## WB316LT T.I.G. WELDING WIRE

<b>Classifications</b>	AWS A5.9 : ER316L      BSEN12072-00 : G19 12 3L									
<b>Product Description</b>	316L stainless steel, solid TIG wire.									
<b>Applications</b>	WB316LT 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.									
<b>Wire Composition(Weight %)</b>	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	
<b>min.</b>	-	1.0	0.25	-	-	18.0	11.0	2.0	-	
<b>max.</b>	0.03	2.5	0.65	0.03	0.03	20.0	14.0	3.0	0.50	
<b>Typical All-Weld Metal Mechanical Properties</b>	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 @ -196 Deg C as-welded					Joules		34J Min (50J Typical)		

<b>Wire Dia (mm)</b>		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	<b>min.</b>	-	-	-	-	80	80	80
	<b>max.</b>	-	-	-	-	120	120	120
<b>Volt Range (Volts)</b>	<b>min.</b>	-	-	-	-	-	-	-
	<b>max.</b>	-	-	-	-	-	-	-
<b>Packaging Information</b>								
<b>Kg Per Tube</b>		-	-	-	-	5	5	5
<b>Storage</b>	<b>Storage</b> 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%.							
<b>Gases</b>	<b>Gas</b> Pure Argon  <b>Flow Rate</b> 7-10 l/min							

### Current Conditions DC- and Welding Positions

