

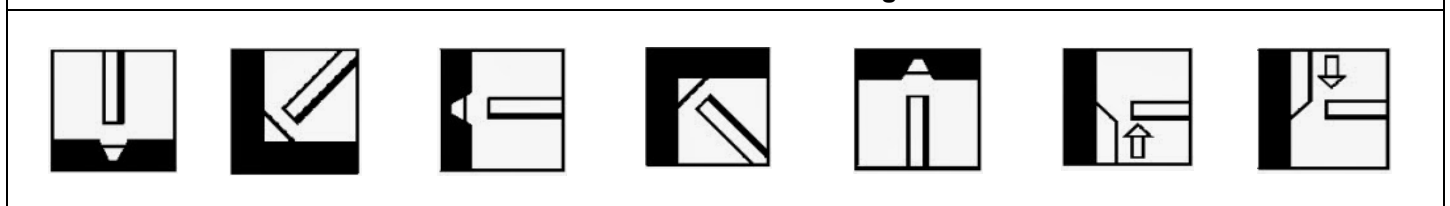


WB316LM MIG WELDING WIRE

Classifications	AWS A5.9: ER316LSi BS EN 14343-A: G 19 12 3 LSi									
Product Description	316L stainless steel, solid MIG wire that meets L & Si grades.									
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 (Wt. %)		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 ²		510 min.					
	Yield Stress/0.2% Proof Stress		N/mm ²		320 min.					
	Elongation on 5D		%		25 min.					
	Impact Energy CV @ -196°C		Joules		34 min. (50J Typical)					
	As welded									

Wire Dia. (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	80	120	160	180	-	-
	max.	-	180	240	260	340	-	-
Volt Range (Volts)	min.	-	17	17	18	20	-	-
	max.	-	20	23	26	29	-	-
Packaging Information								
Kg Per Reel		-	0.7/15	15	15	15	-	-
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 Argon + 2%O ₂ or Argon + 2-3%CO ₂				Flow Rate 15-20 L/min			

Current Conditions DC+ and Welding Positions



Approvals: CE