



WB316HM MIG WELDING WIRE

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|---|---|--------------------------------|-----|-------------------|------|--------------|------|------|-----|------|--|
| Classifications | AWS A5.9: ER316H BS EN ISO 14343-A: G 19 12 3 H | | | | | | | | | | |
| Product Description | 316H austenitic stainless steel, solid MIG wire. | | | | | | | | | | |
| Applications | <p>WB316HT is suitable for the repair and welding of 316/316H austenitic stainless steels. Suitable for use in high temperature corrosive environments up to 800°C under long term creep conditions.</p> <p>Also suitable for welding type 321/321H, 347/347H grades in high service temperatures.</p> <p>Typical applications :- Steam piping, superheater headers, furnace parts, Nuclear power stations etc.</p> <p>Ferrite in the 3-8 FN range.</p> | | | | | | | | | | |
| Wire Composition (Wt. %) | | C | Mn | Si | S | P | Cr | Ni | Mo | Cu | |
| min. | | 0.04 | 1.0 | 0.30 | - | - | 18.0 | 11.0 | 2.0 | - | |
| max. | | 0.08 | 2.5 | 0.65 | 0.02 | 0.03 | 20.0 | 14.0 | 3.0 | 0.30 | |
| Typical All-Weld Metal Mechanical Properties | | Ultimate Tensile Strength | | N/mm ² | | Typical >650 | | | | | |
| | | Yield Stress/0.2% Proof Stress | | N/mm ² | | Typical >460 | | | | | |
| | | Elongation on 5D | | % | | Typical 35 | | | | | |
| | | Impact Energy CV @ +20°C | | Joules | | Typical 75 | | | | | |
| | | As welded | | | | | | | | | |

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|------------------------------|---|-------|-------|-------|-------|-------|-------|-------|
| Wire Dia. (mm) | | 0.6mm | 0.8mm | 1.0mm | 1.2mm | 1.6mm | 2.4mm | 3.2mm |
| Current Range (Amps) | min. | - | - | 100 | 100 | 200 | - | - |
| | max. | - | - | 200 | 300 | 380 | - | - |
| Volt Range (Volts) | min. | - | - | 14 | 15 | 22 | - | - |
| | max. | - | - | 22 | 28 | 32 | - | - |
| Packaging Information | | | | | | | | |
| Kg Per Reel | | - | - | - | - | - | - | - |
| 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

