HILCHROME W316L

TIG rods - stainless steel - acid resistant

AWS A5.9: ER 316L
EN ISO 14343-A: W 19 12 3 L
Werkstoffnr. 1.4430

Wire type:
TIG Solid wire

Current:

Welding positions:

Shielding gas:
I1 = Pure Ar

Hilchrome W316L is our solid wire for TIG welding low carbon 17Cr12Ni3Mo austenitic acid resistant stainless steel grades like AISI 316, 316L. Universal in applications but typical for all industries where superior corrosion resistance is required: textile industry, paper mills, chemical industry, cellulose industry etc., resistance to general and intergranular corrosion (up to 400ºC), good resistance to hot cracking. To be used in combination with tungsten electrodes type WS2 WITSTAR®.

Base materials to be welded:

- ASTM/AISI Gr. 316, 316L, 316LN, 316Cb, 316Ti
- WNr 1.4583, 1.4435, 1.4436, 1.4404, 1.4401, 1.4571 1.4580, 1.4406*, 1.4429*
  * without postweld quenching
- CrNiMo 17 12 3 and similar stainless steel grades

Applications:

- Shipbuilding & Offshore
- Power Generation
- General fabrication & construction
- Repair & Maintenance
- Process Industry

Equivalent product in alternative welding process:

SMAW	GMAW	FCAW	GTAW	SAW	Gas welding / brazing
Hilchrome 316R	Hilchrome G316L Si	-	-	-	-

Chemical composition, wt.% weld metal – typical:

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb	V	Al
0,03	1,70	0,60			19,0	12,5	2,5				

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 320	≥ 550	≥ 35	+20ºC ≥ 80 -120°C ≥ 35

Notes: properties under pure Argon gas shielding

Packaging data:

Dia. mm.	Length mm.	Weight / package kg.
1,0	1000	5
1,2	1000	5
1,6	1000	5
2,0	1000	5
2,4	1000	5
3,2	1000	5