THS-316L (ER316L)

STAINLESS STEEL MIG WELDING WIRE

AWS A5.9 ER316L
NB/T 47018 S316L
GB/T 29713 S316L
YB/H022Cr19Ni12Mo2

APPLICATION

Welding 00Cr17Ni12Mo2 (SUS316L) and similar materials in petrochemical equipment.

CHARACTERISTICS

THS-316L is an extra-low-carbon 19% Cr-12% Ni-2% Mo stainless steel filler wire. Molybdenum provides good corrosion resistance to acetic acid, sulfurous acid, phosphoric acid, and salts. It offers a stable arc, good bead appearance, and all-position welding capability.

PRECAUTIONS

Remove rust, oil, moisture, and other contaminants from the workpiece before welding. Use Ar + 1-3% O_2 shielding gas for MIG welding. Establish a suitable welding procedure for the actual production conditions.

WELDING POSITIONS



MECHANICAL PROPERTIES

Items	Tensile strength (MPa)	Elongation (%)
Typical results	580	38

WIRE CHEMICAL COMPOSITION (%)

Items	C	Mn	Si	Cr	Ni	Mo	P	S	Cu
Requirements	≤0.030	1.00-2.50	0.30-0.65	18.00-20.00	11.00-14.00	2.00-3.00	≤0.025	≤0.020	≤0.75
Typical results	0.020	1.68	0.52	19.10	12.80	2.65	0.020	0.012	0.01

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