



TIG 316LSi



Standards

AWS 5.9
ER 316LSi

EN ISO 14343-A
W 19 12 3 LSi

W. Nr.
1.4430

Description & applications

Filler material in solid metal sticks for TIG welding of austenitic stainless steels containing Molybdenum type 316, 316L, 316 Ti/Nb, as well as Molybdenum-free stainless steels type 304, 304L. The presence of Molybdenum brings several advantages : good corrosion resistance in chloride-containing environments and improved creep resistance up to 400 °C. The high Silicon content improves wettability .

Typical chemical composition (%)

C max	Mn	Si	Cr	Ni	Mo	S max	P Max	Fe
0.025	1.8	0.9	19.0	12.0	2.6	0.02	0.02	Base

Typical mechanical properties of all-weld metal

Rm	Rp 0,2	A5	KV-196°C
600 MPa	410 MPa	35 %	45 J

Operating parameters

Shielding gas recommendations :

EN ISO 14175 I1 : 100 % Argon / 6-12 l/mn

Root : Argon, Nitrogen 3- 6 l/mn



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