

ER316LCF

TIG (GTAW)

SOLID WIRE FOR CRYOGENIC 316L APPLICATIONS

PRODUCT DESCRIPTION

Solid wire for TIG welding.

CLASSIFICATIONS

AWS A5.9M	ER316L
ISO 14343-A	W 19 12 3 L
ISO 14343-B	SS316L

ASME IX QUALIFICATION

QW432	F-No 6
QW442	A-No 8

CHEMICAL COMPOSITION (WIRE WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	FN
Min.	--	1.0	0.30	--	--	18.0	11.0	2.5	--	3
Max.	0.025	2.0	0.65	0.020	0.030	20.0	14.0	3.0	0.3	8
Typical	0.01	1.4	0.5	0.01	0.015	18.5	12.8	2.6	0.15	6

ALL-WELD MECHANICAL PROPERTIES

As welded	Min.	Typical
Tensile strength (MPa)	510	605
0.2% proof strength (MPa)	320	465
Elongation (%) 4d	30	50
5d	25	45
Impact ISO-V(J) -130°C	--	> 100
-196°C	--	> 60
Lateral expansion * (mm) -196°C	0.38	1.0

TYPICAL OPERATING PARAMETERS

Shielding	Current	Diameter (mm)	Voltage
Argon	DC-	2.4	100A, 12V

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
1.6	5	PE TUBE	TER316LCF-16
2.0	5	PE TUBE	TER316LCF-20
2.4	5	PE TUBE	TER316LCF-24
3.2	5	PE TUBE	TER316LCF-32

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.specialalloys.eu for any updated information.