

KM-316LSi

Classification

Shielding Gas:	Ar+1~2%O ₂	AWS A5.9/A5.9M	ER316LSi
	Ar+1~2%CO ₂	AS/NZS ISO 14343	B SS316LSi

Applications and Features

- (1) Weld metal is austenite structure with 18%Cr-12%Ni-2%Mo-Si.
- (2) Superior corrosion resistance to acetic acid, phosphoric acid, acetate and phosphate due to additional Mo content.
- (3) Ideal for welding sheets and pipes of chemical vessels, such as AISI 316, 316L steel.

Welding Instruction

- (1) Use Ar blend with 1~2%O₂ for high current, spray transfer welding .
- (2) Use Ar blend with 1~2%CO₂ for low current, short-circuit transfer welding. (

Typical Chemical Composition of Wire (wt%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.021	0.74	1.62	0.012	0.009	19.23	12.33	2.31

Typical Mechanical Properties of Weld Metal (Shielding Gas : Ar+1%O₂)

Tensile Strength MPa	Yield Strength MPa	Elongation %
580	400	40

Size and Suggested Operating Range (DC+)

Shielding Gas		Diameter (mm)				
		0.8	0.9	1.0	1.2	1.6
Ar+1~2%CO ₂	Amp	40~120	60~140	80~160	100~210	—
	Volt	15~20	15~21	16~22	17~22	—
Ar+1~2%O ₂	Amp	160~210	170~260	180~280	200~300	220~330
	Volt	24~28	24~30	24~30	24~30	24~32

Diam.	1kg Spool	5kg Spool	15 kg Spool
0.6mm		KM3160605	
0.8mm	KM3160801	KM3160805	KM3160815
0.9mm		KM3160905	KM3160915
1.0mm		KM3161005	KM3161015
1.2mm		KM3161205	KM3161215
1.6mm			KM3161615

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