

GEN 316LHS Welding Wire and Rod

GEN 316LHS shares the same characteristics as GEN 316L. The high silicon content allows better arc stability along with smoother bead appearance while the low carbon content offers excellent resistance against carbide precipitation.

CONFORMANCES

AWS A5.9/A5.9M	:	ER316LSi
ASME SFA-A5.9	:	ER316LSi
ISO 14343B	:	SS316LSi

AWS CHEMICAL COMPOSITION (TYPICAL)

%C	%Cr	%Ni	%Mo	%Mn
0.03 max	18.0 – 20.0	11.0 – 14.0	2.0 – 3.0	1.0 – 2.5
0.016	18.4	11.9	2.5	1.7
%Si	%P	%S	%Cu	
0.65 – 1.00	0.03 max	0.03 max	0.75 max	
0.84	0.02	0.01	0.16	

TYPICAL WELD METAL MECHANICAL PROPERTIES

Yield Strength	:	58,000 psi
Tensile Strength	:	86,000 psi
Elongation	:	35 %

TYPICAL WELDING PARAMETERS

Process	Diameter		Voltage	Amperage	Gas/Flux
TIG (GTAW)	1/16"	1.6 mm	14 – 17	80 – 150	100% Ar
	3/32"	2.4 mm	15 – 20	150 – 250	100% Ar
	1/8"	3.2 mm	16 – 20	200 – 375	100% Ar
MIG (GMAW)	.035"	0.9 mm	22 – 23	180 – 210	98%Ar – 2%O ₂
	.045"	1.1 mm	23 – 25	190 – 250	98%Ar – 2%O ₂
Sub Arc (SAW)	.093"	2.4 mm	28 – 32	250 – 450	
	.125"	3.2 mm	29 – 33	300 – 500	

*All parameters are suggested as basic guidelines only and will vary depending on joint design, number of passes and other factors.

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED
BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.

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