

❖ Product Description

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| <ul style="list-style-type: none"> I. Extra low carbon 19Cr/12Ni/Mo type stainless steel solid wire II. Good in marine environment due to pitting and corrosion resistance | <ul style="list-style-type: none"> III. High resistance against intergranular corrosion IV. Resistance to SCC, hot cracking and chemical attack upto 850°C V. Radiographic weld quality |
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❖ Range of Application

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| <ul style="list-style-type: none"> I. For welding austenitic alloys represented by AISI316, 316L II. For joining similar grade wrought and cast material | <ul style="list-style-type: none"> III. Application in textile processing, Naval and chemical environments, dye industries. IV. For cladding stainless steels |
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❖ Classification

- AWS/SFA 5.9 ER316-L

❖ % Chemical Composition

Type of Wire		C	Mn	S	Si	Cr	Cu	Mo	P	Ni
ER316-L	Min	-	1.0	-	0.30	18.0	-	2.0	-	11.0
	Max	0.03	2.5	0.03	0.65	20.0	0.75	3.0	0.03	14.0

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charphy "v" Notch Impact @ -30°C
As Welded	490	-	30	-

❖ Wire Size & Welding Position

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| <ul style="list-style-type: none"> • Diameter in mm- 0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60 | <ul style="list-style-type: none"> • Weld Position- All position |
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❖ Current & Gas Flow

- DCEP; 15-22lit/min

❖ Packaging

Sizes Available in mm	0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60								
Packing Code	A	B	C	D	E	F	G	H	I
Packing Available	SD 100	SD200	SD270	SD 270	SD300	SD300	100kg Drum Pack	250kg Drum Pack	350kg Drum Pack
Net Weight of Wire	1KG	2KG	12.5KG	15KG	12.5KG	15KG	100KG	250KG	350KG

Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

SHAKUNT ENTERPRISES PRIVATE LIMITED

Corporate Office: - 619/A, EMMAR DIGITAL GREEN, 6th Floor, Sector-61, GURUGRAM (HARYANA)-122102
E-Mail:- info@shakunt.com

Ludhiana Works:- B-XXIX-595/5,Campa Cola Road,Dhandari Kalan Industrial Area-C,Ludhiana (PUNJAB) INDIA

Dharwad Works:- Plot no.577 C & D,Belur Industrial Area,Dharwad-580011 (KARNATAKA) INDIA

Vadodara Works:- 67-A,G.I.D.C,Majusar,Savli,Vadodara-397115 (GUJARAT) INDIA