TECHNICAL DATA SHEET

parweld
WELDING THE FUTURE

XP ER 316LSi

STAINLESS STEEL

CLASSIFICATIONS

EN ISO 14343-A	AWS A5.9
G 19 12 3 L Si	ER316LSi

KEY FEATURES AND APPLICATIONS

- Solid corrosion resisting chromium-nickel-molybdenum welding wire for welding of austenitic stainless alloys of 18% Cr - 8% Ni and 18% Cr - 10% Ni - 3% Mo-types.
- Has an increased silicon content that promotes weld pool fluidity to give a smooth deposit appearance.
- This alloy has a low carbon content which makes it particularly recommended where there is a risk of intergranular corrosion.
- Ideal for service temperature up to 400°C max.
- Commonly used for applications needing strong corrosion resistance, like those found in acidic or chlorinated environments, hot water tanks, architecture, roofing, and the food processing and chemical industries.

BASE MATERIALS

1.4401 X5CrNiMo17-12-2, 1.4404 X2CrNiMo17-12-2, 1.4409 GX2CrNiMo19-11-2, 1.4429 X2CrNiMoN17-12-3, 1.4432 X2CrNiMo17-12-3, 1.4435 X2CrNiMo18-14-3, 1.4436 X3CrNiMo17-12-3, 1.4571 X6CrNiMoTi17-12-2 UNS S31600, S31603, S31635, S31640, S31653 AISI 316L, 316Ti, 316Cb

CHEMICAL COMPOSITION OF WIRE %

	C	Si	Mn	P	S	Cr	Ni	Mo	Cu
MIN	-	0.65	1.0	-	-	18.0	11.0	2.5	-
MAX	0.03	1.2	2.5	0.03	0.02	20.0	14.0	3.0	0.5

Single values are maximum values according to EN ISO 14343

MECHANICAL PROPERTIES OF ALL-WELD METAL - TYPICAL (MIN.) VALUES

Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)
475 (≥320)	630 (≥510)	36 (≥25)

Test data for mechanical properties are not guaranteed since actual as welded conditions depend on numerous variables

OPERATING DATA

Shielding Gases	Polarity
EN ISO 14175 - M12, M13	DC+

PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Spool	Weight (kg)	Packaging
XP30250	0.6	S200	5	200
XP30252	0.8	S200	5	200
XP30254	1.0	S200	5	200
XP30260	0.8	BS300	15	72
XP30262	1.0	BS300	15	72
XP30264	1.2	BS300	15	72

This information is subject to change and was accurate to the best of our knowledge at the time of printing. Please refer to www.parweld.com for the latest revision.