

## MIDALLOY ER316/316H BARE WIRE

### CLASSIFICATION

- AWS 5.9 Class ER316/ER316H / ASME SFA 5.9 Class ER316/ER316H
- UNS# S31680 A#8 F#6

### DESCRIPTION

- MIDALLOY ER316/ER316H stainless steel wire is used for GMAW, GTAW, and SAW welding.

### APPLICATIONS

- MIDALLOY ER316/ER316H is used for joining type 316 and similar alloys.
- The presence of molybdenum provides creek resistance at elevated temperatures and pitting resistance in a halide atmosphere.
- Rapid corrosion of ER316 weld metal may occur when three factors co-exist:
  1. The presence of a continuous or semi-continuous network of ferrite in the weld metal microstructure.
  2. A composition balance of the weld metal giving a chromium-molybdenum ratio of less than 82 to 1.
  3. Immersion of the weld metal in a corrosive medium.

### TYPICAL CHEMISTRY

C	Mn	Si	Cr	Ni	Mo	S	P	N	Cu
.055	1.65	.40	19.0	12.0	2.50	.009	.015	.05	.05

### TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	88,500 PSI
YIELD STRENGTH	58,500 PSI
ELONGATION IN 2"	34%

### RECOMMENDED WELDING PARAMETERS

PROCESS	DIAMETER	VOLTAGE	AMPERAGE	GAS/FLUX*
TIG (GTAW)	1/16"	14-18	90-130	100% Ar
	3/32"	15-20	120-175	100% Ar
	1/8"	15-20	150-220	100% Ar
MIG (GMAW)	.035" SHORT ARC	16-26	70-160	69%Ar-30%He-1%O <sub>2</sub>
	.035" SPRAY ARC	26-31	150-230	92%Ar-8%Co <sub>2</sub> or
	.045" SPRAY ARC	28-32	180-280	98%Ar-2%O <sub>2</sub>
SUB ARC (SAW)	3/32"	28-30	275-350	Record IN or
	1/8"	29-32	350-450	Record IND 24

### STANDARD PACKAGING

- TIG 10 lb. tube/60 lb. carton
- MIG 30 lb. spool/1200 lb. pallet
- SUB ARC 60 lb. coil/1440 lb. pallet

10/16/09

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Office and Corporate Warehouse  
 630 Axminister Drive  
 Fenton, MO 63026 • 636-349-6000 • 800-776-3300  
 Fax 636-349-2240

