



S. R. Industries

STAR ARC ER316/316L

ER316/316L is used for welding types 316 and 316L stainless steels. It has a maximum carbon content of .03% to reduce the possibility of formation of intergranular carbide precipitation. This low carbon alloy is not as strong as 316H at elevated temperatures. This filler metal is primarily used for welding low carbon molybdenum bearing austenitic alloys.

AWS Specification : AWS A5.9/A5.9M:2006

AWS Classification	ER316
	ER316L
Welding Current	DCEP
Typical Wire Chemistry	
C	0.08
Cr	18.0 - 20.0
Ni	11.0 - 14.0
Mo	2.0 - 3.0
Mn	1.0 - 2.5
Si	0.30 - 0.65
P	0.03
S	0.03
Cu	0.75
Typical Mechanical Properties (As Welded)	
Yield Strength, ksi	58

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<i>Tensile Strength, ksi</i>	<i>86</i>
<i>Elongation%, min,</i>	<i>36</i>
<i>Welding Positions</i>	<i>F,V,OH,H</i>
<i>Available Diameters MIG with Operating Range in Amps</i>	
<i>.023"</i>	<i>35 - 70</i>
<i>.030"</i>	<i>50 - 100</i>
<i>.035"</i>	<i>160 - 210</i>
<i>.045"</i>	<i>180 - 250</i>
<i>Available Diameters TIG with Operating Range in Amps</i>	
<i>.035"</i>	<i>60 - 90</i>
<i>.045"</i>	<i>80 - 110</i>
<i>1/16"</i>	<i>90 - 130</i>
<i>3/32"</i>	<i>120 - 175</i>
<i>1/8"</i>	<i>150 - 220</i>
<i>5/32"</i>	<i>170 - 350</i>

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