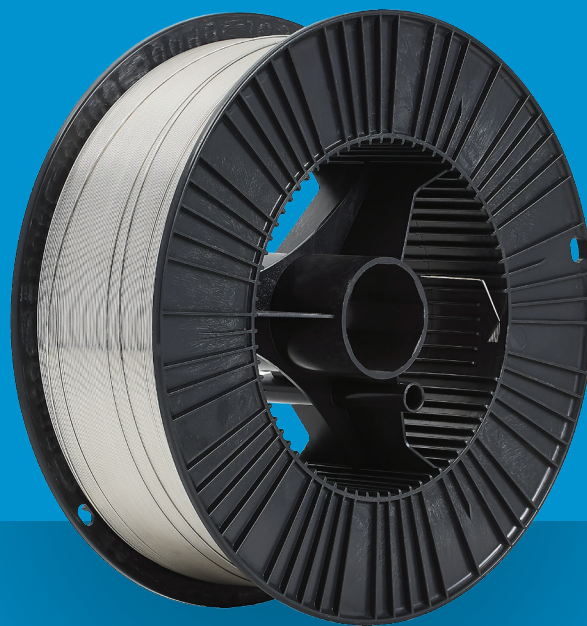


AUTOCRAFT 316LSi

PRODUCT DATA SHEET



**PREMIUM QUALITY,
LOW CARBON STAINLESS
STEEL WIRE**



GAS METAL ARC WELDING (MIG) WIRES

AUTOCRAFT 316LSi

- For the GMAW Welding of 18%Cr / 8%Ni and 18%Cr / 8%Ni / 3%Mo Type Stainless Steels.
- Extra Low Carbon (< 0.03%) Weld Deposits for Resistance to Intergranular Corrosion.
- High Silicon level for Improved Arc Stability and Increased Weld Pool Fluidity and Edge Wetting.
- NEW Ultrafeed Matt Finish.

TYPICAL WIRE ANALYSIS:

C:	0.02%
Mn:	1.52%
Si:	0.70%
Cr:	18.85%
Ni:	12.75%
Mo:	2.45%
P:	0.022%
S:	0.002%
Fe:	Balance

CLASSIFICATIONS:

ISO AS/NZS: 14343

B SS316LSi

AWS/ASME-SFA A5.9:

ER316LSi

FERRITE NUMBER:

5 - 10 FN

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

ARGON + 1-3% O₂:

0.2% Proof Stress	470 MPa
Tensile Strength	640 MPa
Elongation	38%
CVN Impact Values	90 J av @ -60°C

DESCRIPTION AND APPLICATIONS:

Autocraft 316LSi is a premium quality, low carbon 19% Cr / 13% Ni / 2.5Mo stainless steel wire for the Gas Metal Arc Welding (GMAW) of Molybdenum bearing stainless steels; in particular 316, 318 and 316L alloys.

Autocraft 316LSi is also suitable for the general welding of other 300 and 400 series stainless steels including 301, 302, 304/304L, 321, 347, 410 and 430.

The low carbon content ensures immunity from carbide precipitation and intergranular corrosion when welding low carbon stainless steel grades and the higher Silicon level offers improved arc stability, bead shape and edge wetting.

COMPARABLE CIGWELD PRODUCTS:

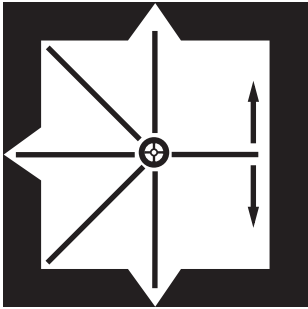
- Satinchrome 316L-17 electrode
- AWS A5.4: E316L-17
- Comweld 316L TiG rod
- AWS A5.9: ER316L
- Verti-Cor 316LT FCAW wires
- AWS A5.22: E316LT1-1/4

RECOMMENDED* SHIELDING GAS:

AS 4882:	SG-A0-2
	SG-AC-2
	SG-ACH-2/2
	SG-ACHe-2/35
ISO 14175 / AWS A5.32:	M13*- CERT SUPPLIED
	M12
	M11
Ar+O2(1-3%) or Argon+CO2 (2-5%) or Ar+CO2(1-4%)+H2(1-5%) or Ar+CO2(1-4%)+He(35%)	

WELDING POSITIONS:

All positional welding applications.



PACKAGING & OPERATING DATA:

These machine settings are a guide only. Actual voltage and welding current used will depend on machine characteristics, plate thickness, run size, shielding gas and operator technique etc.

WIRE DIAMETER (MM)	VOLTAGE RANGE (VOLTS)	WIRE FEED SPEED (METERS/MIN)	CURRENT RANGE (AMPS)	PACK TYPE*	PACK WEIGHT	HANG-TUBE PART NO.
0.8	16-20	5.0-15.0	60-150	Mini Spool (4 per pack)	4 x 1kg	721285
0.8	16-20	5.0-15.0	60-150	Handi Spool	5kg	720288
0.9	16-24	4.5-15.0	70-200	Handi Spool	5kg	720283
0.9	16-24	4.5-15.0	70-200	Spool	15kg	721286
1.2	20-28	3.0-10.0	150-280	Spool	15kg	721287

* Spool (ø300mm);

