

Classification

AWS A 5.9 : ER 316 L EN 12072 : W 19 12 3 L

Typical weld metalchemical composition (%)

C	Mn	Si	Cr	Ni	Mo	Cu	S	P
0.03 max.	1.50-2.20	0.30-0.65	18.00-20.00	11.00-14.00	2.00-3.00	0.75 max.	0.03 max.	0.03 max.

All weld metal mechanical properties (typical)

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Impact energy ISO-V(J) 20°C
≥ 350	≥ 510	≥ 30	≥ 47

Description

ITR 316L is an extra low carbon 19 Cr/ 12 Ni/ 3 Mo type stainless steel TIG rod similar in composition to ER 316L. Suitable for the welding or surfacing of having similar compositions. The weld metal has excellent creep strength up to 850°C. Ferrite controlled between 4 to 8%. The weld metal has excellent crack resistance, intergranular corrosion and creep resistance properties. Excellent mechanical properties.

Materials to be welded

1.4401 (X4CrNiMo17-12-2), 1.4435 (X2CrNiMo18-14-3)
 1.4571 (X6CrNiMoTi17-12-2), 1.4583 (X10CrNiMoNb18-12)
 AISI 316L

Current conditions

DC (-)

Storage

Keep dry and avoid condensation

Packing data

Size (mm) DxL	0.80 x 1000	0.90 x 1000	1.00 x 1000	1.20 x 1000	1.60 x 1000	2.00 x 1000	2.40 x 1000	3.20 x 1000	4.00 x 1000
Net wt. per tube (kg)	5	5	5	5	5	5	5	5	5
Net wt. per box (kg)	20	20	20	20	20	20	20	20	20

Welding positions

