

## Applications

TIG welding of low carbon 18%Cr-12%Ni-2%Mo steel.

## Characteristics on Usage

ST-316L is a filler rod for TIG welding with pure Ar gas.  
As the weld metal contains ferrite, its crack resistibility is excellent.  
Both its bead appearance and weldability are good.  
Resistance to corrosion and heat is extremely good.

### Typical Chemical Composition of Wire (%)

C	Si	Mn	Cr	Ni	Mo
0.02	0.38	1.85	18.8	12.4	2.5

### Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in <sup>2</sup> )	EL (%)	CVN-Impact Value J(ft.lbs) 0°C (32°F)
570 (82,700)	44	140 (103)

### Typical Welding Conditions (DC-)

Size mm(in)	Currents A	Gas Flow (ℓ /min.)	Shielding gas
1.2 (.045) ~ 2.0 (5/64)	50 ~ 100	25	Ar
1.6 (1/16) ~ 3.2 (1/8)	100 ~ 200		
2.4 (3/32) ~ 3.2 (1/8)	200 ~ 300		
3.2 (1/8)	300 ~ 400		

### Approval

KR, ABS, DNV, GL, LR, NK, BV, CCS