

## MIG-MAG Wires Stainless and Heat resistant steels

Inertfil 316LSi is a stainless steel solid wire conforming to ER 316LSi with C=0.03% max and Si ~ 0,85 %. Excellent mechanical properties and resistance to chemical corrosion, suitable for welding or surfacing stainless steels having similar chemical compositions. Excellent bead appearance.

| Classification |                      |
|----------------|----------------------|
| AWS            | A5.9: ER 316L Si     |
| EN             | 12072: G 19 12 3L Si |

| Approvals | Grades |
|-----------|--------|
| TÜV       |        |

see Appendix, Classification Society Approvals, for details pag. 521

### Analysis of all-weld metal (Typical values in %)

| C    | Mn   | Si   | P       | S       | Cr | Ni    | Mo   | Nb | Cu | N | Ferrite |
|------|------|------|---------|---------|----|-------|------|----|----|---|---------|
| 0.02 | 1.40 | 0.85 | ≤ 0.025 | ≤ 0.020 | 19 | 12.50 | 2.60 | -  | -  | - | 5-10    |

### All-weld metal Mechanical Properties

| Heat Treatment | Yield Strength<br>N/mm <sup>2</sup> | Tensile Strength<br>N/mm <sup>2</sup> | Elongation<br>A5 (%) | Impact Energy<br>ISO - V (J)<br>20°C | Hardness |
|----------------|-------------------------------------|---------------------------------------|----------------------|--------------------------------------|----------|
| As Welded      | ≥ 350                               | ≥ 510                                 | ≥ 30                 | ≥ 47                                 | -        |

Gas test: Acc. To EN 439: M13(Cargal1)

**Shielding Gas:** Acc. To EN 439: M13(Cargal1)

### Materials

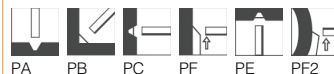
1.4401 (X4CrNiMo17-12-2), 1.4435 (X2CrNiMo18-14-3)  
1.4571 (X6CrNiMoTi17-12-2), 1.4583 (X10CrNiMoNb18-12)  
AISI 316L

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC+



**Packaging data:** BS300 Kg. 15

|           |     |     |     |     |     |
|-----------|-----|-----|-----|-----|-----|
| Diameters | 0,6 | 0,8 | 1,0 | 1,2 | 1,6 |
|-----------|-----|-----|-----|-----|-----|