



exocor™

Stainless Steel BARE WIRE DATA SHEET

executive 316L

DESCRIPTION

Executive 316L is the same as ER316, except that the carbon content is limited to a maximum of 0.03% in order to reduce the possibility of formation of intergranular carbide precipitation. This filler metal is primarily used for welding low carbon molybdenum-bearing austenitic alloys. This low carbon alloy is not as strong at elevated temperatures as Executive 316H.

TYPICAL CHEMICAL VALUES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu
0.02	19.0	12.0	2.3	1.8	0.4	0.02	0.02	0.75

WELDING PARAMETERS

PROCESS	SIZE	VOLTS	AMPS	SPEED OF WELDING / GAS FLOW	SHIELDING GAS / FLUX
SAW	.093	29 - 32	300 - 350	20 - 30 IPM	Record IN Flux
	.125	29 - 32	400 - 550	20 - 30 IPM	Record IN Flux
	.156	29 - 32	500 - 650	20 - 30 IPM	Record IN Flux
GMAW	.035	29 - 33	160 - 180	30 - 50 CFH	98/99% Ar + 2/1% O ₂
	.045	29 - 33	180 - 220	30 - 50 CFH	or
	.062	29 - 33	210 - 250	30 - 50 CFH	97% Ar + 3% CO ₂
GTAW	.093	Direct Current; Electrode -		30 - 40 CFH	100% Ar

MECHANICAL PROPERTIES

Tensile Strength:	86,000 PSI	590 MPA
Yield Strength:	58,000 PSI	400 MPA
Elongation:	36%	

CLASSIFICATION

Wire chemistry has been optimized for best performance and conforms to **AWS/SFA 5.9, Class ER316L**, and is certified by the Canadian Welding Bureau to AWS A5.9. ISO 14343A, Class 19 12 3 L and ISO 14343B, Class SS316L.