

DESCRIPTION

Executive 316/316L wire is designed to provide clean and consistent welds with excellent feedability and minimal clean-up. By maintaining tight control from the country of melt to the design of the spool Executive wire provides welders with the highest quality stainless bare wire.

Executive 316/316L is a molybdenum bearing alloy which increases pitting corrosion resistance.

APPLICATIONS & FEATURES

Executive 316/316L is used in pressure piping, vessel manufacturing, and general manufacturing and fabrication and has a maximum carbon level of 0.03% which enhances the resistance to intergranular corrosion.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	N	
0.012	18.29	11.35	2.52	1.55	0.56	0.023	0.003	0.13	0.068	
Tensile Strength:		80,700 PSI min		Yield Strength:		55,000 PSI min		Elongation:		40%

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux	
GMAW - Short	.035"	21-22	160-200	30 to 50 CFH	90% He/7.5% Ar/2.5% CO ₂ or 1%-5% O ₂ /Balance Ar	
	.045"	22-23	180-210			
	.062"	23-24	200-220			
	- Spray	.035"	23-25			190-260
		.045"	25-28			250-330
		.062"	28-31			310-350
GTAW	.062" - .125"	Direct Current; Electrode -		30 to 40 CFH	100% Ar	
SAW	.093"	29-32	300-350		Record IND 24 or Record IN	
	.125"	29-32	400-550			

STANDARD PACKAGING

GMAW (MIG)	33-lb wire baskets	1,980-lb pallet
	11-lb plastic spools	11-lb box
	2-lb plastic spools	8-lb box
GTAW (TIG)	10-lb plastic tube	40-lb box
SAW	60-lb wire coil	1,200-lb pallet

CLASSIFICATION

AWS/SFA 5.9, Class **ER316/316L**
Certified by the Canadian Welding Bureau (CWB) to AWS A5.9.

