

# BW-316LSi

## Professional Welding Wire

High quality stainless steel GMAW wire.



Specification: AWS/ASME-SFA A5.9: ER316LSi.

### Applications & Features

BW-316LSi is a stainless steel Mig welding wire. Weld metal is austenite structure with 18%Cr-12%Ni-2%Mo-Si. Ideal for welding sheets and pipes of chemical vessels, such as AISI 316, 316L steel.

### Characteristics

Excellent weldability and puddle fluidity.  
Superior corrosion resistance to acetic acid, phosphoric acid, acetate and phosphate due to additional Mo content.

### Notes on Usage

Use Argon mixed gas with 1-2% O<sub>2</sub> for high current spray transfer welding.  
Use Argon mixed gas with 1-2% CO<sub>2</sub> for low current short circuit transfer welding.

### Approvals:

TUV, ABS, BV, CWB

### Part Numbers

P/N: 2038 (0.9mm 15kg Spool)

P/N: 2039 (1.2mm 15kg Spool)



### Typical chemical composition of weld metal (wt%): (Shielding Gas: Ar+1%O<sub>2</sub>)

C	Si	Mn	P	S	Cr	Ni	Mo
0.021	0.74	1.62	0.012	0.009	19.23	12.33	2.31

### Typical mechanical properties of weld metal : (Shielding Gas Ar+1%O<sub>2</sub>)

Tensile Strength N/mm <sup>2</sup> (kgf/mm)	Yield Strength N/mm <sup>2</sup> (kgf/mm)	Elongation %
580(59.1)	400 (40.8)	40

### Size & suggested operating range: (DC+):

Operating Range		2038 (0.9mm)	2039 (1.2mm)
Ar+1-2% CO <sub>2</sub>	Amp	60-140	100-210
	Volt	15-21	17-22
Ar+1-2% O <sub>2</sub>	Amp	170-260	200-300
	Volt	24-30	24-30