

AUTOCRAFT 316LSi



- ▲ For the GMAW Welding of 18%Cr / 8%Ni and 18%Cr / 8%Ni / 3%Mo Type Stainless Steels.
- ▲ Extra Low Carbon (< 0.03%) Weld Deposits for Resistance to Intergranular Corrosion.
- ▲ High Silicon level for Improved Arc Stability and Increased Weld Pool Fluidity and Edge Wetting.
- ▲ NEW Ultrafeed Matt Finish.

Classifications:

AS 2717.3:	ES316LSi.
AWS/ASME-SFA A5.9:	ER316LSi.

Description and Applications:

Autocraft 316LSi is a premium quality, low carbon 19% Cr / 13% Ni / 2.5Mo stainless steel wire for the Gas Metal Arc Welding (GMAW) of Molybdenum bearing stainless steels; in particular 316, 318 and 316L alloys.

Autocraft 316LSi is also suitable for the general welding of other 300 and 400 series stainless steels including 301, 302, 304/304L, 321, 347, 410 and 430.

The low carbon content ensures immunity from carbide precipitation and intergranular corrosion when welding low carbon stainless steel grades and the higher Silicon level offers improved arc stability, bead shape and edge wetting.

TYPICAL WIRE ANALYSIS:

C: 0.02%	Mn: 1.52%	Si: 0.70%
Cr: 18.85%	Ni: 12.75%	Mo: 2.45%
P: 0.022%	S: 0.002%	Fe: Balance

FERRITE NUMBER:

5 – 10 FN

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

	Argon + 1-3% O ₂ :
0.2% Proof Stress	470 MPa
Tensile Strength	640 MPa
Elongation	38%
CVN Impact Valves	90 J av @ -60°C

COMPARABLE CIGWELD PRODUCTS:

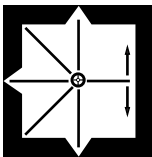
Satinrome 316L-17 electrode
AWS A5.4: E316L-17

Comweld 316L TIG rod
AWS A5.9: ER316L

Shieldrome 316LT FCAW wires
AWS A5.22: E316LT-1/4

RECOMMENDED SHIELDING GAS:

- Ar + 1-3% O₂ or equivalent ISO14175: M13
- Ar + 2-5% CO₂ or equivalent ISO14175: M12
- Ar + 1-4% CO₂ + 1-5% H₂ or equivalent ISO14175: M11 (1)
- Ar + 1-4% CO₂ + 35% He



All positional welding applications

Packaging and Operating Data:

These machine settings are a guide only. Actual voltage and welding current used will depend on machine characteristics, plate thickness, run size, shielding gas and operator technique etc.

Wire Dia mm	Voltage Range (volts)	Wire Feed Speed (metres/min)	Current Range (amps)	Pack Type*	Pack Weight	Part No
0.8	16–20	5.0–15.0	60–150	Mini spool (4 per pack)	4 x 1kg	721285
0.9	16–24	4.5–15.0	70–200	Handi spool	5kg	720283
0.9	16–24	4.5–15.0	70–200	Spool	15kg	721286
1.0	16–24	4.5–15.0	70–200	Spool	15kg	722386
1.2	20–28	3.0–10.0	150–280	Spool	15kg	721287

* Mini spool (ø100mm); Handi spool (ø200mm); Spool (ø300mm).