

# ES TIG 316L

GTAW  
ER316L

**ESWECO**  
*The Art of Welding*

## Description

Bare, corrosion-resistant, chromium-nickel-molybdenum rods for welding austenitic stainless alloys of the 18% Cr-8% Ni and 18% Cr-10% Ni-3% Mo types.

ES TIG 316L has good general corrosion resistance, particularly to corrosion in acid and chlorinated environments. The alloy has a low carbon content which makes it particularly recommended when there is a risk of intergranular corrosion. The alloy is widely used in the chemical and food-processing industries, as well as in shipbuilding and various types of architectural structures.

## Current

DC (-)

## Classifications

SFA/AWS A5.9	ER316L
EN 12072	W 19 12 3 L
Werkstoffnummer	~1.4430

## Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
<0.03	0.5	1.8	19.0	12.5	2.8	<0.3

## Typical mech. Properties all weld metal

Yield stress, MPa	470
Tensile strength, MPa	650
Elongation, %	32

## Charpy V

Test temps, °C	Impact values, J
+20	140
-60	110
-196	70

## Welding parameters

Diameter, mm	Length, mm	Weight of rods/box, kg
1.6	1000	5.0
2.0	1000	5.0
2.4	1000	5.0