



**MANUFACTURERS OF A DIVERSE RANGE OF
ADVANCED WELDING CONSUMABLES**

**SECTION
13**

WI-0304 DS170 NSN-316LR Rev. 1, Date 01.07.2013

NSN-316LR	FILLER ROD FOR WELDING LOW-CARBON AUSTENITIC STAINLESS STEELS CONTAINING A NOMINAL 19Cr-12Ni- 2.5Mo										DATA SHEET NO. 170		
	SPECIFICATION			AWS A5.9			JIS Z 3321			BS EN 12072			
CLASSIFICATION			ER316L			Y316L			W 19 12 3 L				
WELD METAL ANALYSIS COMPOSITION % BY Wt.			C	Cr	Ni	Mo	Mn	Si	P	S	Cu	Fe	N
MIN			-	18	11	2.0	1.0	0.30	-	-	-		
MAX			0.03	20	14	3.0	2.5	0.65	0.03	0.03	0.75		
TYPICAL			0.02	19	12	2.3	1.8	0.4	0.02	0.001	0.24	Bal.	0.02
WELD METAL PROPERTIES (ALL WELD METAL)			PROPERTY		UNITS	MINIMUM	TYPICAL		OTHERS				
			Tensile strength		N/mm ²	490	564						
			0.2% Proof stress		N/mm ²	-	400						
			Elongation on 4d		%	30	40						
			Impact energy -196 °C		J	-	60						
OTHER DATA			Argon mainly use as shielding gas				UNCONTROLLED						
RELATED PRODUCTS			Please contact our Technical Department for detail.										