



HILCO HILCHROME G316LSi

MAG wires – stainless steel – acid resistant

AWS A5.9: ER 316LSi

EN ISO 14343-A: G 19 12 3 L Si

Werkstoffnr. 1.4430

Wire type:
MAG Solid wire

Current:



Welding positions:



Shielding gas:
M12-M13

Hilchrome G316LSi is our solid wire for MAG welding low carbon 17Cr12Ni3Mo austenitic acid resistant stainless steel grades like AISI 316, 316L. Universal in applications but typical for all industries where superior corrosion resistance is required: textile industry, paper mills, chemical industry, cellulose industry etc., resistance to general and intergranular corrosion (up to 400°C), good resistance to hot cracking.

Base materials to be welded:

- ASTM/AISI Gr. 316, 316L, 316LN, 316Cb, 316Ti
- WNr 1.4583, 1.4435, 1.4436, 1.4404, 1.4401, 1.4571
1.4580, 1.4406*, 1.4429*
* without postweld quenching
- CrNiMo 17 12 3 and similar stainless steel grades

Applications:

- Shipbuilding & Offshore
- Power Generation
- General fabrication & construction
- Repair & Maintenance
- Process Industry

Chemical composition, wt.% weld metal – typical:

C	Mn	Si	Cr	Ni	Mo
0,02	1,7	0,8	18,8	12,5	2,8

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 320	≥ 510	≥ 25	20°C ≥ 70

Note: properties under M13

Packaging and welding data:

Dia. mm.	Spool type	Weight / spool kg.
0,8	BS300	15
1,0	BS300	15
1,2	BS300	15
1,6	BS300	15