



## **M-90 ER316L**

### **FEATURES**

- \*EXCELLENT CRACK RESISTANCE
- \*EXCELLENT RESISTANCE TO HEAT
- EXCELLENT ARC STABILITY AND BEAD WETTING

### **APPLICATION**

- \*EXCELLENT CRACK RESISTANCE
- \*EXCELLENT RESISTANCE TO HEAT
- EXCELLENT ARC STABILITY AND BEAD WETTING

### **CLASSIFICATION**

- \*A5.9/ ASME SFA5.9 ER316L

### **CHEMICAL COMPOSITIONS**

C	Si	Mn	P	S	CR	Ni	MO
0.02	0.38	1.85			18.8	12.4	2.5

### **MECHANICAL PROPERTIES**

Y.S	T.S	EL	Temp.	CVN-Impact Value
N/mm2 (lbs/in 2 )	N/mm2 (lbs/in 2 )	(%)	oC ( oF)	J (ft lbs)
	570 (82,700)	44	0 (32)	104(103)

### **WELDING PARAMETERS**

DIAMETER (mm)	1.6	2.4
LENGTH (mm)	1000	1000
CURRENT (amps)		

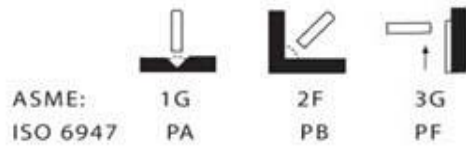
### **CURRENT**

\*DC -

### **GAS**

Ar

## WELDING POSITIONS



### *Current*

= +	~	(U <sub>o</sub> : 60V)
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