

# MIGINOX 316L / TIGINOX 316L

**Classification**  
AWSA/SFA 5.9 : ER 316L

Approvals : MIGINOX 316L  
TOYO ER 316L

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## Characteristics

Extra low carbon 19 Cr/12 Ni/Mo stainless steel filler with controlled ferrite content of 4 to 8% for maximum resistance to cracking, inter-granular corrosion and creep. The weld metal has good creep strength upto temperature of 850°C.

## Typical Applications

For welding of stainless steels represented by AISI types 316L and 316. Welding of tanks, coils used in the pulp, paper textile industries etc.

### Typical Wire Chemistry

C	Mn	Si	Cr	Ni	Mo	S	P
0.03 max	1.0-2.5	0.30-0.65	18.0-20.0	11-14	2-3.0	0.03 max	0.03 max

Properties of weld metal with 98% Ar + 2% O<sub>2</sub> gas Current Condition : DC (+) in GMAW

### All Weld Mechanical Properties As welded condition

UTS MPa	490
Elongation % (L=4xd)	30-38

The chemistry & mechanical properties of the weld will vary with the type of shielding gas used.

### Packing Specifications

Supplied in D 300 plastic spools - layer wound / Weight - 12.5 Kg

### Packing Specifications for MIGINOX 316L

Size mm	2.0	1.6	1.2	0.80
Kgs	12.5	12.5	12.5	12.5

Each plastic spool is sealed in a polyethylene bag and then packed in a corrugated box which is shrink-wrapped.

Also available as MIGINOX 316L (C)

### Packing Data for TIGINOX 316L

Dia., mm	1.0	1.2	1.6	2.0	2.5
Length,mm	1000	1000	1000	1000	1000
Net wt per tube,kg	5	5	5	5	5
No of Plastic Tubes per Box	4	4	4	4	4
Net wt,Box,kg	20	20	20	20	20

### Special Test :

Test Type	Remarks
IGC (As per ASTM - A 262)	* MIGINOX - 316L passed in practice - "E", "B"



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