



Part No	Spool Size	Wire Size
P2-MW316L04/08	0.9kg 100mm	0.8mm
P2-MW316L04/09	0.9kg 100mm	0.9mm
2-MW316L08/08	5kg 200mm	0.8mm
2-MW316L08/09	5kg 200mm	0.9mm
2-MW316L12/09	12.5kg 300mm	0.9mm

### Technical Data

#### PROPERTIES

Description	Solid stainless-steel welding wire Similar to 316L grade, with higher silicon content for improved edge wetting and arc stability.								
Classifications	AWS A5.9/A5.9M ER316LSi AS/NZS ISO 14343 B SS316LSi								
Typical Composition (%)	Element	C	Si	Mn	P	S	Cr	Ni	Mo
	%	<0.03	0.65-1.00	1.0-2.5	<0.03	<0.03	18.0-20.0	11.0-14.0	2.0-3.0
Typical Mechanical Properties	Tensile Strength 580 Mpa Yield Strength 400 Mpa Elongation 40%								

#### APPLICATION

Recommended For	Welding of common 300 & 400 series stainless-steels
Typical Uses	General stainless-steel fabrication Food processing equipment Water/liquid processing equipment

#### OPERATING DATA

Shielding Gas	Argon + 1-2% Oxygen, or Argon + 1.5-2.5% CO <sub>2</sub> , or Argon + Helium + CO <sub>2</sub> variations Attempting to MIG weld stainless-steel with 100% Argon will result in poor weld quality and is NOT recommended.
Polarity	DC+ (Wire/torch positive, Earth negative)
Typical Parameters	0.8mm: 40-120A / 15-20V 0.9mm: 60-140A / 15-21V 1.2mm: 100-210A / 17-22V
Positions	All-positional

