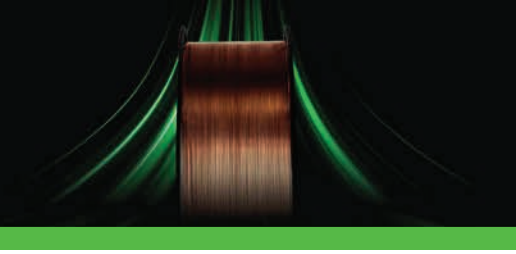
BT WELD



BT WELD 316LSI STAINLESS STEEL MIG WIRE

KEY FACTS

- Precision layer wound wire
- Low carbon content reduces the risk of carbide prescription
- Easy starting and smooth feeding wire
- Higher silicon content improves weld edge wetting

DESCRIPTION

MIG wire similar to ER316L though with added silicon. The low carbon content ensures immunity from carbide precipitation and intergranular corrosion when welding low carbon stainless steel grades and the higher silicon level offers improved arc stability, bead shape and edge wetting.

CLASSIFICATIONS

AWS A5.9 ER316LSi
JIS Z3321 YS316LSi
DIN8556 SG X2 CrNiMo 19 12

RECOMMENDED SHIELDING GAS

Argon or Argon / CO2 mix.
98/99% Argon + 2/1% Oxygen
97% Argon + 3% CO2

WELDING POSITIONS

All positional, including vertical-down



PA PB PC PD PE PF PG

APPLICATIONS

Ideal for welding stainless steel of similar composition (316 & 316L and in some cases 304 and 304L) as well as joining mild and low alloy. Use when good appearance is important.

- Food processing equipment
- Water processing filtration plants
- General stainless fabrications

TYPICAL WIRE ANALYSIS

C Carbon	Mn Manganese	Si Silicon	Cr Chromium	Ni Nickel
< 0.03	1.0 – 2.5	0.65 – 1.00	19.5 – 22.0	9.0 – 11.0
Mo **Molybdenum**	**S** **Sulphur**	**P** **Phosphorus**	**Cu** **Copper**	**Fe** **Iron**
< 0.75	< 0.03	< 0.03	< 0.75	Remainder

TYPICAL WELD MECHANICAL PROPERTIES

0.2% Proof Stress	> 390 N/mm^2
Tensile Strength	595 N/mm^2
Elongation (5xD)	38%

PACKAGING & ORDERING INFORMATION

Size	Packet	Part Number
0.8mm	1kg	200075
0.9mm	1kg	200076
0.8mm	5kg	200080
0.9mm	5kg	200081
0.8mm	15kg	200086
0.9mm	15kg	200087
1.2mm	15kg	200089
Pallets are 1080kg (72 D300 spools)		

Disclaimer: The above information is provided as a guide; actual welding current and voltage will depend on the welding machine characteristics, which will vary fro model to model. Other variables include run length and size, plate thickness, operator technique and gas type (if used). The user must evaluate the process, application and recommended professional advice. Under no circumstance will Dynaweld or its affiliates be liable for misuse or application of products; this is entirely up to the user's ability.