

INERTROD 316LSi is a W 19 12 3 LSi/ER 316LSi type solid TIG welding rod depositing a low C-19Cr12Ni2.5Mo weld metal. Suitable for use with Ar shielding gas.

INERTROD 316LSi is used for the welding of 316 and 316L grade stainless steels, in a wide range of applications including the fabrication of pipe and plate. The higher Si level promotes a smooth weld bead shape of even appearance with excellent toe blending, particularly in fillet welds. The weld metal provides good resistance to pitting and crevice corrosion by non-oxidising acids. Used for applications where service temperatures <400°C.

Classification		Approvals	Grade
EN ISO	14343-A: W 19 12 3 L Si	DB	●
AWS	A5.9: ER 316LSi	TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo
0.02	1.4	0.85	≤ 0.025	≤ 0.020	19	12.5	2.6

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				20 °C	-120 °C
As Welded	≥ 350	≥ 510	≥ 30	≥ 80	≥ 32

Gas test: 100% Ar

Shielding Gas - EN ISO 14175 : I1

Materials

1.4571 (X6CrNiMoTi17-12-2), 1.4583 (X10CrNiMoNb18-12)

AISI 316L

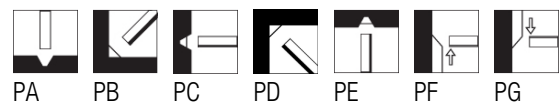
1.4401 (X4CrNiMo17-12-2), 1.4435 (X2CrNiMo18-14-3)

Storage

Keep dry and avoid condensation

Current condition and welding position

DC-



Packaging data

Diam. (mm)	Packaging Type	Weight (kg)	Code
2.0	TUB	5	●
2.4	TUB	5	●