



**MANUFACTURERS OF A DIVERSE RANGE OF
ADVANCED WELDING CONSUMABLES**

**SECTION
13**

WI-0304 DS170 NSB-316LR Rev. 1, Date 01.07.2013

NSB-316LR	FILLER ROD FOR WELDING LOW-CARBON AUSTENITIC STAINLESS STEELS CONTAINING A NOMINAL 19Cr-12Ni- 2.5Mo										DATA SHEET NO. 170
	SPECIFICATION	AWS A5.9	JIS Z 3321	BS EN 12072							
CLASSIFICATION	ER316L	Y316L	W 19 12 3 L								
WELD METAL ANALYSIS COMPOSITION % BY Wt.	C	Cr	Ni	Mo	Mn	Si	P	S	Cu	Fe	N
MIN	-	18	11	2.0	1.0	0.30	-	-	-		
MAX	0.03	20	14	3.0	2.5	0.65	0.03	0.03	0.75		
TYPICAL	0.02	19	12	2.3	1.8	0.4	0.02	0.001	0.24	Bal.	0.02
WELD METAL PROPERTIES (ALL WELD METAL)	PROPERTY	UNITS	MINIMUM	TYPICAL	OTHERS						
	Tensile strength	N/mm ²	490	564							
	0.2% Proof stress	N/mm ²	-	400							
	Elongation on 4d	%	30	40							
	Impact energy -196 °C	J	-	60							
OTHER DATA	Argon mainly use as shielding gas										
RELATED PRODUCTS	Please contact our Technical Department for detail.										