



Techalloy 316LHS

Description

Techalloy 316LHS is similar to 316L, with higher silicon content for optimum ease and speed in MIG welding and smooth bead appearance. This alloy is intended for joining 316 type stainless steels.

Specifications & Approvals:

AWS A5.9 ER316LHS

UNS S31688

ISO 14343:2009 (19 12 3 L Si)

CWB

Typical Chemical Composition

C	Mn	Si	Cr	Mo	Ni	Nb	N	S	P	Cu	FN
.022	1.80	.85	19.25	2.45	12.6			.004	.013		8

Typical Mechanical Properties

Tensile Strength	86,500 PSI	600 MPA
Yield Strength	58,500 PSI	400 MPA
Elongation	36%	

Welding Parameters

	Shielding	Gas Flow	Diameter	Voltage	Amperage
Mig Welding	98/99% Argon + 2/1% Oxygen 97% Argon + 3% CO2	30 to 50 CFH	.035" (0.9mm) .045" (1.14mm) .062" (1.6mm))	26 to 29 28 TO 32 29 TO 33	160/210 180/250 200/280

Standard Packages:

Mig Wire– 33# wire basket		
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