Unibraze 316LSi

CLASSIFICATIONS: AWS A5.9/ASME SFA 5.9 Class ER316LSi UNS S31688

DESCRIPTION: Unibraze 316LSi is used for welding low carbon molybdenum-bearing austenitic alloys. This filler metal is similar to Unibraze ER316L, with higher silicon content for optimum ease in welding and smooth bead appearance. Higher productivity could be realized in the MIG welding process.

TYPICAL CHEMISTRY:

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	FN (WRC)
.03 max	18.0-20.0	11.0-14.0	2.0-3.0	1.0-2.5	.65-1.0	.03 max	.03 max	.75 max	8

TYPICAL MECHANICAL PROPERTIES:

Tensile Strength	86,500 psi (600 MPa)
Yield Strength	58,500 psi (400 MPa)
Elongation	36%

TYPICAL WELDING PARAMETERS:

	Shielding Gas	Gas Flow	Diameter	Voltage	Amperage
MIG	98/99% Ar +2/1% O 97%Ar + 3% CO_2	30 to 50 CFH	.035" (.9mm) .045" (1.14mm) .062" (1.6mm)	26-29 28-32 29-33	160 /210 180/250 200/280