

FabCOR[®] 316LSi



AWS A5.22: EC316LSi

WELDING POSITIONS:



FEATURES:

- Little or no slag
- Low spatter
- Soft arc
- Higher travel speeds & higher deposition rates
- Good for vertical down (30-60° incline) welding

BENEFITS:

- Requires little or no clean-up time
- Promotes good bead appearance
- Excellent welder appeal
- Increases productivity
- Increases throughput time

APPLICATIONS:

- Used for joining 316, 316L, and 318 stainless steel

WIRE TYPE: Gas-shielded, metal-powder, metal-cored wire

SHIELDING GAS: 98% Argon (Ar)/2% Oxygen (O₂)

TYPE OF CURRENT: Direct Current Electrode Positive (DCEP)

STANDARD DIAMETERS: 0.045" (1.2 mm)

RE-DRYING: Not recommended

STORAGE: Product should be stored in a dry, enclosed environment, and in its original intact packaging

TYPICAL WELD METAL CHEMISTRY* (Chem Pad):

Weld Metal Analysis (%)	98% Ar/2% O ₂	AWS Spec
Carbon (C)	0.025	0.03 max
Manganese (Mn)	1.50	1.0-2.5
Silicon (Si)	0.85	0.65-1.00
Phosphorus (P)	0.025	0.03 max
Sulphur (S)	0.020	0.03 max
Copper (Cu)	0.35	0.75 max
Chromium (Cr)	19.1	18.0-20.0
Nickel (Ni)	12.4	11.0-14.0
Molybdenum (Mo)	2.62	2.0-3.0

OTHER PROPERTIES* (As Welded):

Mechanical Tests	Typical	AWS Spec
DeLong Ferrite Number	13	Not required
Schaeffler Number	11	Not required
WRC Number (1992)	13	Not required

Note: Nitrogen (N) assumed to be 0.06% for calculation purposes.

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Hobart Brothers Company expressly disclaims any liability incurred from any reliance thereon. Typical data are those obtained when welded and tested in accordance with the AWS A5.22 specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by Hobart Brothers Company.

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Diameter		Weld Position	Amps	Volts	Wire Feed Speed		Deposition Rate		Contact Tip to Work Distance	
Inches	(mm)				in/min	(m/min)	lbs/hr	(kg/hr)	Inches	(mm)
0.045	(1.2)	Flat & Horizontal**	185	22	300	(7.6)	8.0	(3.6)	1/2	(13)
0.045	(1.2)	Flat & Horizontal**	275	25	550	(14.0)	14.0	(6.3)	1/2	(13)
0.045	(1.2)	Flat & Horizontal**	340	29	780	(19.8)	20.22	(9.2)	1/2	(13)

RECOMMENDED WELDING PROCEDURES:

- GENERAL:** DCEP (electrode positive, work negative)
ARC LENGTH: Short (less than half the diameter of the electrode)
FLAT & HORIZONTAL: Angle electrode 10-15° from 90° (Push or Drag)

STANDARD DIAMETERS AND PACKAGES: For a complete list of diameters and packaging, please contact Hobart Brothers at (800) 424-1543 or (937) 332-5188 for International Customer Service.

Diameter	30-lb. (14kg)
Inches (mm)	Spool
0.045 (1.2)	S691612-026

CONFORMANCES AND APPROVALS:

- **AWS A5.22**
- **ASME SFA 5.22**, Class EC316LSi
- **CWB**, 98% Ar/Balance O₂, EC316LSi, (1.2 diameter)

**Spray transfer w/98% Ar/2% O₂ gas. Pulsed spray transfer allows out-of-position welding.

TECHNICAL QUESTIONS? For technical support of Hobart Filler Metals products, contact the Applications Engineering department by phone toll-free at 1-800-532-2618 or by e-mail at Applications.Engineering@hobartbrothers.com

CAUTION:

Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standard Z49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36th St., Miami, FL 33166 (can also be downloaded online at www.aws.org); OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210

Material Safety Data Sheets on any Hobart Brothers Company product may be obtained from Hobart Customer Service or at www.hobartbrothers.com.

Because Hobart Brothers Company is constantly improving products, Hobart reserves the right to change design and/or specifications without notice.

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