

Inweld 316H

AWS A5.9 ER316H

Chemical Composition of Inweld 316H

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu	Other
Balance	0.04- 0.08	18.0- 20.0	11.0- 14.0	2.0- 3.0	1.0- 2.5	0.30- 0.65	0.03	0.03	---	0.75	---

Single values are maximum unless otherwise specified.

Description and Applications

Inweld ER316H is the same as ER316, except that the allowable carbon content has been restricted to the higher portion of the 316 range. Carbon content in the range of 0.04 to 0.08 wt.% provides higher strength at elevated temperatures. It is used to weld 316H base metal.

Typical Weld Metal Properties

	<u>AWS Spec</u>
Tensile Strength:	88,000 psi
Yield Strength:	58,000 psi
Elongation:	34%

Recommended Parameters

GMAW

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>
0.035"	16-26	70-160
0.035" (Spray)	26-31	150-230
0.045" (Spray)	28-32	180-280

GTAW

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>
1/16"	14-18	90-130
3/32"	15-20	120-175
1/8"	15-20	150-220

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