

INERTROD 316L is a W 19 12 3L/ER 316L type solid TIG welding rod depositing a low C-19Cr12Ni2.6Mo weld metal. Suitable for use mainly with Ar shielding gas.

INERTROD 316L is used for the welding of 316 and 316L grade stainless steel. It is used for a wide range of applications including pipework and plate fabrication, vessel production etc. Batch with controlled low ferrite number is available for cryogenic applications.

The weld metal has good resistance to crevice corrosion by oxidising acids.

Classification		Approvals	Grade
EN ISO	14343-A: W 19 12 3L	DB	●
AWS	A5.9: ER 316L	TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo
0.020	1.4	0.45	≤ 0.025	≤ 0.020	19	12.5	2.6

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-196 °C
As Welded	≥ 350	≥ 510	≥ 30	≥ 130	≥ 32

Gas test: 100% Ar

Shielding Gas - EN ISO 14175 : I1

Materials

1.4571 (X6CrNiMoTi17-12-2), 1.4583 (X10CrNiMoNb18-12)

1.4401 (X4CrNiMo17-12-2), 1.4435 (X2CrNiMo18-14-3)

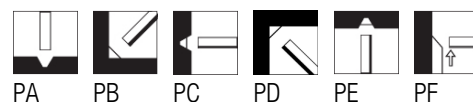
AISI 316L

Storage

Keep dry and avoid condensation

Current condition and welding position

DC-



Packaging data

Diam. (mm)	Packaging Type	Weight (kg)	Code
1.0	TUB	5	●