

# TASETO Welding Materials

Bare Stainless Steel Rods

For Gas Tungsten Arc Welding

## TG316L

### ● Applicable Specification

JIS Z 3321 YS316L  
AWS A5.9 ER316L

### ● Identification Color

End Face : Green

### ● Applications and Characteristics

TASETO TG316L has the same uses as TG316, but its resistibility to intergranular corrosion has been improved by decreasing the carbon content compared with TG316. TG316L is mainly used for welding of Type 316L stainless steel used for important chemical equipment where corrosion resistibility is required.

TG316L2 and TG316L1 whose carbon content is further decreased are also available.

### ● Chemical Composition of Wire (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.020	0.43	1.76	0.010	0.011	13.43	19.23	2.31	0.15

### ● Mechanical Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	4D Elongation (%)
Typical	420	554	42.5

### ● Corrosion Resistance of All Weld Metal

* Typical Corrosion Resistance	5.01g/m <sup>2</sup> ·h (5% Sulfuric Acid Test)
	180° bend without any defects
	(Copper Sulfate-Sulfuric Acid Test: PWHT 650°C × 2h)

### ● Sizes Available and Recommended Welding Currents (DCEN)

Rod Diameter (mm)	0.8	0.9	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0	6.0
Rod Length (mm)	1000											
Welding Current (A)	50~80		50~120			100~200			150~250		220~280	

\*Rod Diameter 0.8, 0.9, 6.0 mm : Made to order products