

Description:

HOBART 316LMnPro is solid wire for fully austenitic stainless steels and low temperature steels, It suited for corrosion resistant in seawater environment and has very good corrosion resistance to acids such as nitric acid. Excellent impact properties can be met at low temperatures. -269°C.

Well suited for joining and cladding applications with matching and similar austenitic CrNi(N) and CrNiMo(Mn,N) steels/cast steel grades.

Typical Wire Analysis (wt%)

Typical value	C	Mn	Si	P	S	Cr	Ni	Mo	Cu	N
	0.032	4.6	0.39	0.015	0.002	18.4	17.9	3.97	0.007	0.16

Typical Mechanical Properties of Weld Metal

Shielding gas	Yield strength MPa	Tensile strength MPa	Elongation (%)	Test Temp. °C	Charpy V-Notch J
With 98%Ar +2%O ₂	386	615	41	-269	85

Sizes and Recommended Current Range (DC+)

Diameter (mm)		0.9	1.2
Weld Position		Flat & Horizontal	
Amps		150-225	190-300
Volts		23-26	24-28
Stick-Out (mm)		13-19	13-19
Spray Transfer	98%Ar + 2%O2 Flow Rate (l/min)	16.5	20

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

For Welding with Stainless Cut-Lengths (DCEN, 100% Argon Shield, Tungsten Electrode)

Diameter (mm)	Metal Thickness(mm)	Number of Passes	Tungsten Size(mm)	Amps
1.6	1.6	1	1.6	140-160
2.4	2.4	1	1.6	170-200
2.4	3.2	1	1.6	170-200
3.2	4.8	1	2.4	210-230

Sizes Available

MIG Wire (mm)	0.9 /1.0 /1.2 /1.6
TIG Rod (mm)	1.6 /2.0 /2.4 /3.2

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