Replaces 2209

AWS A5.9: ER316LMn mod.
EN ISO 14343-A: W20/G20 16 3 Mn N L mod.

HOBART 316LMnPro (TGA/MIG)

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℃.

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%)

	C	Mn	Si	P	S	Cr	Ni	Mo	Cu	N
Typical value	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. ℃	Charpy V-Notch J
With 98%Ar +2%O2	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

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