

# BLUE MAX<sup>®</sup> MIG 316LCF

Stainless ▪ AWS ER316L

## KEY FEATURES

- Controlled Low Ferrite (Range 3-5)
- Charpy V-Notch test results capable of exceeding 27 J (20 ft•lbf) @ -196°C (-320°F)
- Exceeds 15 mils (0.38 mm) of lateral expansion @ -196°C (-320°F)
- Q2 Lot<sup>®</sup> - Certificates showing actual wire composition available online

## WELDING POSITIONS

All

## CONFORMANCES

AWS A5: ER316 ER316L

## TYPICAL APPLICATIONS

- LNG Storage
- Cryogenic Vessels and Piping

## TYPICAL BASE METALS

- 316L stainless steel

## SHIELDING GAS

98% Ar / 2% O

## DIAMETERS / PACKAGING

Diameter in (mm)	33 lb (15 kg) Steel Spool
0.035 (0.9)	ED034925
0.045 (1.1)	ED034926

## WIRE COMPOSITION<sup>(1)</sup> – As Required per AWS A5.9

	%C	%Cr	%Ni	%Mo	%Mn
<b>Requirements - AWS ER316L</b>	0.03 max	18.0 - 20.0	11.0 - 14.0	2.0 - 3.0	1.0 - 2.5
<b>Typical Results<sup>(3)</sup></b>	0.01	18.5	12.1	2.4	1.6
	%Si	%P	%S	%Cu	FN
<b>Requirements - AWS ER316L</b>	0.30 - 0.65	0.03 max	0.03 max	0.75 max	Not Required
<b>Typical Results<sup>(3)</sup></b>	0.36	0.02	0.01	0.09	6 - 12

## MECHANICAL PROPERTIES<sup>(1)</sup>

	Yield Strength <sup>(2)</sup> MPa (ksi)	Tensile Strength MPa (ksi)	Elongation %	Charpy V-Notch J (ft•lbf) -196°C (-320°F)	Lateral Expansion mils (mm) -196°C (-320°F)
<b>Typical Results<sup>(3)</sup></b> As-Welded with 98% Ar/2% O <sub>2</sub>	410 (69)	580 (85)	36	42 (56)	27 (0.69)

<sup>(1)</sup>Typical wire composition. <sup>(2)</sup>Measured with 0.2% offset <sup>(3)</sup>See test results disclaimer

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED

Fumes from the normal use of some welding products can contain significant quantities of components - such as chromium and manganese - which can lower the 5.0 mg/m<sup>3</sup> maximum exposure guideline for general welding fume.

BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.