



# HILCO HILCHROME W316L

TIG rods - stainless steel - acid resistant

AWS A5.9: ER 316L

EN ISO 14343-A: W 19 12 3 L

Werkstoffnr. 1.4430

**Wire type:**  
TIG Solid wire

**Current:**



**Welding positions:**



**Shielding gas:**

I1

Hilchrome W316L is our solid wire for TIG welding low carbon 17Cr12Ni3Mo austenitic acid resistant stainless steel grades like AISi 316, 316L. Universal in applications but typical for all industries where superior corrosion resistance is required: textile industry, paper mills, chemical industry, cellulose industry etc., resistance to general and intergranular corrosion (up to 400°C), good resistance to hot cracking. To be used in combination with tungsten electrodes type WS2 WITSTAR®.

**Base materials to be welded:**

- ASTM/AISI Gr. 316, 316L, 316LN, 316Cb, 316Ti
- WNr 1.4583, 1.4435, 1.4436, 1.4404, 1.4401, 1.4571, 1.4580, 1.4406\*, 1.4429\*
- \* without postweld quenching
- CrNiMo 17 12 3 and similar stainless steel grades

**Applications:**

- Shipbuilding & Offshore
- Power Generation
- General fabrication & construction
- Repair & Maintenance
- Process Industry

**Chemical composition, wt.% weld metal – typical:**

C	Mn	Si	Cr	Ni	Mo
0,02	1,70	0,50	18,5	12,3	2,6

**Mechanical properties, weld metal – typical:**

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 320	≥ 510	≥ 25	20°C ≥ 100 -196°C ≥ 32

**Packaging data:**

Dia. mm.	Length mm.	Weight / package kg.
1,6	1000	5
2,0	1000	5
2,4	1000	5
3,2	1000	5