



**SW-316H**

**DESCRIPTION & APPLICATION**

High Carbon MIG/TIG Filler wire for the joining and overlay of Stainless Steels of similar composition, i.e. 316H. Joining of most Austenitic Stainless. Used in the food and Dairy Industry and where higher strength than 316L is required. Austenitic deposit with up to 10% Ferrite, slightly magnetic.

**BASE MATERIALS**

300 series Austenitic Stainless Steel, particularly Molybdenum bearing.

**MECHANICAL PROPERTIES**

>550n/mm  
**UTS n/mm**

>420  
**YIELD 0.2%**

>26  
**ELONG A5%**

95  
**IMPACT (J) +20**

**METAL WELD COMPOSITION %**

C	Si	Mn	Cr	Ni	Mo	S	P	Fe
0.045	0.45	1.8	19.0	12.0	2.5	0.02	0.025	BAL

**PACKAGING**

15kg Spools (MIG)  
5kg Tubes (TIG)

**DIAMETERS**

0.8, 1.0, 1.2mm (MIG)  
1.6, 2.4, 3.2mm (TIG)

**WELDING INSTRUCTIONS**

Shielding gas MIG 5% or 20% CO<sub>2</sub> in Argon, or 2% Argon-Ox.  
TIG 100% Argon. Do not allow the base material to overheat, maintain interpass temperature below 150°C. For MIG, use dip transfer as preferred method. Suggested welding parameters using Argon/5% CO<sub>2</sub>, Amps 250, Volts 25. Using Argon/O<sub>2</sub> increase Voltage. Final settings to be at Welder preference.