

SelectAlloy 316LMn-C Mod

Stainless Steel / Gas Shielded / Metal Cored

PRODUCT DATA SHEET

FEATURES

- Similar chemical composition to EC316LMn with modifications to keep ferrite ultra low
- Ideal for welding applications where ultra low ferrite numbers are required

CONFORMANCES

AWS A5.22

ECG

DIAMETERS [in (mm)]

0.045 (1.2)

POSITIONS



SHIELDING GAS

Ar + 0.5-3% CO₂, Ar + 0.5-3% O₂
Flow Rate: 40 - 50 CFM

POLARITY

Direct Current Electrode Positive (DCEP)

TYPICAL WELD DEPOSIT CHEMISTRY (WT%)

Shielding Gas	C	Cr	Cu	Mn	Mo	N	Ni	P	S	Si
Argon	0.03	18	0.40	4	2	0.20	13	0.02	<0.001	0.5

TYPICAL MECHANICAL PROPERTIES

Shielding Gas	Tensile Strength ksi (MPa)	Yield Strength ksi (MPa)	Elongation (%)	Weld Condition	PWHT Temp
98%Ar / 2%O ₂	94 (650)	61 (418)	38	As-Welded	-

RECOMMENDED WELDING PARAMETERS

Diameter in (mm)	Shielding Gas	Position	WFS* in/min (m/min)	Amps	Volts	CTWD* in (mm)
0.045 (1.2 mm)	98% Ar/2% O ₂	Flat & Horizontal	325 (8.3)	220	22	1/2 - 5/8 (13 - 16)
		Flat & Horizontal	375 (9.5)	235	23	1/2 - 5/8 (13 - 16)
		Flat & Horizontal	420 (10.7)	250	24	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	500 (12.7)	270	26	5/8 - 3/4 (16 - 19)

* WFS = Wire Feed Speed, CTWD = Contact Tip To Work Distance

PACKAGING [lbs (kgs)]

33 (15) Spools, 60 (27.2) Coils, 500 (226.8) Round Drum, 800 (362.9) Hex Drum, 900 (408.2) Hex Drum

*Some packaging options may not be available depending on diameter and product. Special package options may be available upon request.



Notice: Be sure to follow all your employers safety practices, policies and procedures when using this product. Refer to CSA W117.2 and ANSI Z49.1 Safety in Welding, Cutting and Allied Processes for further information and the manufactures SDS sheet. The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.

STORAGE AND HANDLING

All products should be stored in original packaging, in dry conditions and handled with care. For more information refer to our website.



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600 Enterprise Drive, P.O. Box 259, Fort Loramie, Ohio 45845-0259 • 877-869-4009 • www.Select-SAI.com