

**Specifications:**

AWS A5.9  
 AWS Class ER316LMn  
 ASME SFA 5.9  
 UNS S31682  
 DIN 1.4455

**Properties:**

**Tensile Strength:** 100,000 psi  
**Yield Strength:** 63,000 psi  
**Elongation:** >30%  
**Impacts at -320°F:** 35-38 MILS Lateral Expansion

**Description:**

WT 316LMn is an austenitic stainless steel bare welding wire with no ferrite. WT 316LMn is typically used in welding, repairing, and overlaying of stainless steels like 316L, as well as types like 201, 304L, 316L, and 3% and 9% Nickel steels, when the ferrite levels are needed to be low. WT 316LMn is used for GMAW, GTAW, and SAW welding. It is often used in the cryogenic industry to get a low impact toughness and high strength. Weld metal results performed at -350°F and -452°F result in impact strengths of 25 ft-lbs and 15 mils lateral expansion.

Available in multiple sizes and diameters in spool and wire rods.

**Typical Chemical Composition (Wt%)**

C	Mn	Si	Cr	Ni	Mo	Cu	Cb	S	P	N
0.012	7.03	0.44	21.0	16.50	3.15	0.068	0.005	0.007	0.014	0.186

Note: Single values are maximum unless otherwise noted.

Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of material being welded.

**CAUTION:** Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126: OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.