

Solid Wire Electrode for Submerged Arc Welding

BA-WIRE 316H

Classification: SFA-5.9 – ER316H

Typical analysis and chemical composition acc. to AWS A5.9: (Weight Percent)

Wire electrode	C	Si	Mn	Mo	Ni	Cr	P	S	Cu total
Typical analysis BA-WIRE 316H	0.05	0.45	1.7	2.5	12.3	19.0	0.020	0.013	0.15
ER316H acc. to AWS A5.9	0.04–0.08	0.30–0.65	1.0–2.5	2.0–3.0	11.0–14.0	18.0–20.0	0.03	0.03	0.75

Application:

BA-WIRE 316H is a submerged arc welding wire intended for welding austenitic stainless steels that will operate at high temperatures of 500 – 800 °C, under long term creep conditions. BA-WIRE 316H is also suitable for welding 321/321H and 347/347H grades in high temperature service. Recommended for welding steam piping, superheater headers for the petrochemical industry and power plants.

Base Materials:

- 316/316H, CF10M, BS 316S51, 316S52, 316S53, 316C16, 316C71, UNS S31609
Suitable fluxes: BF 38, WP 380

Flux type suitability is strongly dependent on its application. In combination with the wire electrode the most suitable flux should match the requirements of the plate material as closely as possible under the existing welding conditions. Further information can be obtained from the technical flux data sheets.

Package forms:

Coils, spools, drums and spiders as standard package forms for SAW-wire electrodes, different package forms on request.

Diameter:

1.6 – 4.0 mm; sizes and tolerances acc. to ISO 544 and AWS A5.9.

Wire electrode surface:

Smooth finish free from surface defects and foreign matter.