

## DIFF-FILL 116

STAINLESS STEEL FILLER WIRE 316L  
FOR TIG , MIG , MAG WELDING

DIF-FILL 116 is a solid bare filler wire. Containing typically extra low carbon 19% Cr, 12.5 % Ni, 2.0% Mo. Presence of moly provides creep resistance at elevated temperature up to 850 °C. Pitting and scaling resistance in a halide atmosphere is excellence. Low amount of carbon in the weld metal ensures freedom from intergranular cracking. Use DC ( - ) and argon gas for the best quality welds.

### Applications:

For welding of low carbon molybdenum bearing austenitic stainless steel. Joining and surfacing of AISI 316, 136L, and similar composition steels. Weld clad side of similar composition steels. Used in chemical , textile , food , paint and die industries.

### Specification:

**DIN 8556** : **SG x 2 Cr Ni Mo 19 12**  
**AWS / SFA 5.9** : **ER 316 L**

### Alloy Basis : ( % )

C	Si	Mn	Cr	Ni	Mo	Cu	Fe
0.025 max	0.3-0.65	1.0 – 2.5	18 – 20	11 – 14	2 – 3	0.25 max	BAL

### Properties:

Applicable Gas : Welding Grade Argon ( TIG )  
Argon + 2.5 % Co<sub>2</sub>  
Tensile strength : 540 N /mm<sup>2</sup>  
Elongation : 38 %

### Packing Standards:

Size ( dia mm) - TIG 1.6 mm, 2.0mm, 2.5mm, 3.15mm, 4.00mm  
Length - 1000 mm  
Packing - 5 kg per packet, 20 kg per case  
Spool - MIG welding 0.8 mm,1.2 mm,1.6 mm 12.5 kg per spool.

## DIFFUSION ENGINEERS LIMITED

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