

316L MIG

Typical Weld Metal Properties

	AWS Spec
Tensile Strength:	88,000 psi
Yield Strength:	58,000 psi
Elongation:	34%

Recommended Parameters

GMAW

Wire Diameter	Voltage	Amperage
0.035"	16-26	70-160
0.035" (Spray)	26-31	150-230
0.045" (Spray)	28-32	180-280

GTAW

Wire Diameter	Voltage	Amperage
1/16"	14-18	90-130
3/32"	15-20	120-175
1/8"	15-20	150-220