

# 316L

## 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  |