

# UGIWELD 316LM (MIG 316LSi)

AWS A5.9 ER316LSi

EN ISO 14343-A 19 12 3 LSi



## MIG/MAG Solid wire for welding of corrosion resistant stainless materials.

### General description:

UGIWELD 316LM (MIG 316LSi) is a solid wire for gas metal arc welding (MIG) for welding of corrosion resistant austenitic materials, 316 types and similar.

An increased silicon (Si) content enhances weld pool fluidity and wetting characteristics, resulting in improved bead appearance and reduced risk of lack of fusion.

Purity is a critical factor when welding high-alloyed materials. The weld zone shall be kept completely free from contamination to avoid defects and to preserve corrosion resistance.

The interpass temperature shall not exceed 150 °C, and the heat input should be limited to a maximum of 2.0 kJ/mm to ensure proper weld metal properties and microstructure.

### Welding positions:



### Welding current:

DC+

### Gas flow:

14-18 l/min.

### Chemical composition of welding wire:

| C        | Si       | Mn      | Ni        | Cr        | Mo      | Cu       |  |  |  |
|----------|----------|---------|-----------|-----------|---------|----------|--|--|--|
| Max 0.03 | 0.65-1.0 | 1.0-2.5 | 11.0-14.0 | 18.0-20.0 | 2.5-3.0 | Max 0.50 |  |  |  |

### Shielding gas:

Argon + Oxygen (1 to 3%) or Argon + CO<sub>2</sub> (1 to 2.5%)  
Nitrogen and hydrogen are prohibited in shielding gases

### Mechanical properties of all-weld-metal:

| Yield and Tensile Strengths |                    |                 |  |  |
|-----------------------------|--------------------|-----------------|--|--|
| Yield<br>Mpa(Rp0.2)         | Tensile<br>Mpa(Rm) | Elongation<br>% |  |  |
| 500                         | 620                | 30              |  |  |

### Packaging information:

0,8 mm: 5kg spool / 15kg spool / 250kg drum  
1,0 mm: 5kg spool / 15kg spool / 250kg drum  
1,2 mm: 5kg spool / 15kg spool / 250kg drum  
1,6 mm: 15kg spool / 250kg drum

### Approvals:

DB, CE

### Reference / date:

UGIWELD 316LM (MIG 316LSi),  
English, 15.04.2026.