

# Shield-Bright 316H

AWS A5.22 E316T1-1(4) / JIS Z3323 TS316-FB1

## Description and Application

- Shield-Bright 316H was developed for welding of type 316H stainless steel and can also be used for type 316. It contains a higher carbon level(0.04% min.) than 316L filler metals to give greater high temperature strength. The ferrite content is also lower for high temperature service.

Typically these are found in applications where the service temperature is above 750 °F (400 °C).

Shield-Bright 316H was developed for welding in all positions and performs particularly well in the vertical position with excellent slag removal.

Flux  
CORED  
WIRES

## Shielding Gas : 100%CO<sub>2</sub> or 75%Ar/25%CO<sub>2</sub>

### Typical Mechanical Properties of All Weld Metal

Shielding gas	Yield Point N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	Tensile Strength N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	Elongation (%)
100%CO <sub>2</sub>	452 {46}	595 {61}	35
75%Ar/25%CO <sub>2</sub>	460 {67}	620 {63}	35

### Typical Undiluted Weld Metal Analysis %

Shielding gas	C	Mn	Si	P	S	Cr	Ni	Mo	Ferrite No.
100%CO <sub>2</sub>	0.062	1.51	0.52	0.020	0.006	18.9	11.9	2.60	3-8
75%Ar/25%CO <sub>2</sub>	0.055	1.10	0.70	0.020	0.006	19.0	12.0	2.60	3-8

### Approvals

JIS