

GENERAL DESCRIPTION

Elite 835 is used for welding of 316 and 316L grade stainless steels, in a wide range of applications including the fabrication of pipe and plate. The higher Si level results in a smooth weld bead shape and even appearance with excellent toe blending particularly in fillet welds.

The weld metal has excellent crack and corrosion resistance, intergranular corrosion, and creep resistance properties. Excellent mechanical properties & excellent bead appearance.

MATERIALS TO BE WELDED:

1.4401 (X4CrNiMo17-12-2), 1.4435 (X2CrNiMo18-14-3), AISI 316L

1.4571 (X6CrNiMoTi17-12-2), 1.4583 (X10CrNiMoNb18-12)

APPLICATIONS:

- General stainless-steel fabrication
- Process Industries
- Architectural structures
- Pipes

WELDING POSITIONS



CLASSIFICATION

AWS / ASME-SFA 5.9: ER 316LSi

AS/NZS ISO 14343-B-SS316LSi

RECOMMENDED SHIELDING GASES

EN ISO 14175 : Ar+0.5%≤O2≤3%,

Ar+0.5≤CO2≤5

CHEMICAL COMPOSITION

Wt% - wire	Si	C	Cu	Mn	Ni	Mo	S	Cr	P
	0.65-1.00	0.03max	0.75max	1.60-2.50	11.00-14.00	2.00-3.00	0.03max	18.00-20.00	0.03max

TYPICAL MECHANICAL PROPERTIES

Typical as welded	
Yield Strength	≥ 350
Tensile strength	≥ 510
Elongation A5(%)	≤30%
Impact Energy ASO-V(J) 20°C	≥80

DEPOSITION DATA - DCEP (DC+)

Ar+1~2%CO2	0.9mm Diameter	1.0mm Diameter	1.2mm Diameter
Current (A)	60-140A	80-160A	100-210A
Voltage (V)	15-21V	16-22V	17-22V
Ar+1~2%O2			
Current (A)	160-210A	180-280A	200-300A
Voltage (V)	24-28V	24-30V	24-30V

Welding parameters are a guide only as they are dependent on the machine used, material thickness and operator experience.

No data is to be construed as a recommendation for any welding condition or technique by Euromarc.

CONFORMANCE AND APPROVAL

CE
ABS
LR
TUV
DB

STORAGE

Store all MIG welding wire in their original packaging in a controlled environment of less than 50% relative humidity.

WARNING

Electric shock can kill. Arc rays can injure eyes. Welding fumes are hazardous to your health and may damage lungs and other organs. Use adequate ventilation. Arc rays and sparks can injure eyes and burn skin. Wear correct hand, head, eye and body protection.

Read and understand the Safety Data Sheet for this product.

PACKAGING INFORMATION

Size	Weight	Spool	Part Number / Order code
0.9	12.5kg	D300	VW83500912
1.0	12.5kg	D300	VW83501012
1.2	12.5kg	D300	VW83501212

