



# GOLDCOR® 316LSi

AWS EC316LSi

Replaces: 000401

210-C, INDEX 060214

## DESCRIPTION:

**GOLDCOR 316LSi** is an austenitic stainless steel, gas shielded metal cored wire used to join 316 and 316L stainless steels. It produces a concave bead profile and is formulated to run with 98% Argon and 2% Oxygen shielding gas in the spray transfer mode.

GOLDCOR 316LSi was developed to meet the needs of chemical/food service fabricators that have poor to fair fit up and desire a metal cored wire that can produce a moderately soft arc at good welding speeds.

Features	Benefits
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- Little or no slag
- Low spatter
- Soft arc
- Higher travel speeds & higher deposition rates
- Good for vertical down (30-60° incline) welding

- Requires little or no clean-up time
- Promotes good bead appearance
- Excellent welder appeal
- Increases productivity
- Increases throughput time

**SHIELDING GAS: 98% ARGON/2% OXYGEN**

## TYPICAL WELD METAL CHEMISTRY\* (CHEM PAD):

Weld Metal Analysis		AWS Spec
Carbon (C)	0.020	0.03 max
Manganese (Mn)	1.50	1.0 to 2.5
Phosphorus (P)	0.020	0.03 max
Sulphur (S)	0.010	0.03 max
Silicon (Si)	0.85	0.65 to 1.00
Copper (Cu)	0.20	0.75 max
Chromium (Cr)	19.1	18.0 to 20.0
Nickel (Ni)	12.4	11.0 to 14.0
Molybdenum (Mo)	2.5	2.0 to 3.0

## TYPICAL WELD METAL PROPERTIES\* (AS WELDED): AWS A5.9

DeLong Ferrite Number Range	4-10	not required
Schaeffler Number Range	4-10	not required
WRC Number Range (1992)	4-10	not required

Note: Nitrogen (N) assumed to be 0.06% for calculation purposes.

## CONFORMANCES AND APPROVALS:

- AWS A5.9 • ASME SFA5.9 • Class EC316LSi

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## RECOMMENDED OPERATING PARAMETERS: For Spray Transfer Welding

Diameter Electric Stickout Position	Arc Voltage (Volts)	Current DCEP (+) (Amps)	Approx. Wire Feed Speed (In/Min)	Deposition Rates (lbs/hr)
.045" (1.2 mm)	22	185	300	8.0
1/2" ± 1/8"	<b>25</b>	<b>275</b>	<b>550</b>	<b>14.0</b>
Flat and Horizontal	29	340	780	20.22
1/16" (1.6 mm)	25	200	153	7.5
1" ± 1/4"	<b>29</b>	<b>300</b>	<b>255</b>	<b>12.1</b>
Flat and Horizontal	34	450	600	27.0

The values above were determined with 98/2 (Ar/O<sub>2</sub>), shielding gas. DCEP  
**BOLD**—Optimum parameters for welder appeal.

## AVAILABLE DIAMETERS AND PACKAGES:

Inches	Diameter		30-lb. Spool
		mm	
.045"		1.2	S691612-026
1/16"		1.6	S691619-026

Material Safety Data Sheets on any McKay product may be obtained from McKay Customer Service.

Because McKay is constantly improving products, McKay reserves the right to change design and/or specifications without notice.

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