

## GENERAL DESCRIPTION

Elite 885 is an extra low carbon 19 Cr/ 12 Ni/ 3 Mo /0.85 Si type stainless steel TIG rod suitable for the welding or surfacing of having similar compositions and where increased resistance to pitting corrosion is required. The weld metal has excellent creep strength up to 850°C. Ferrite controlled between 5 to 10%. The weld metal has excellent crack and corrosion resistance, intergranular corrosion, and creep resistance properties. Excellent mechanical properties & excellent bead appearance. Suitable for joining stainless Cr-Ni-Mo and Cr-Ni steels, stabilized or non-stabilized eg: ASTM 316, 316L and 316Ti as well as 304, 304L 321 and 347

## 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

100% Argon

## CHEMICAL COMPOSITION

Wt% - wire	Si	C	Cu	Mn	Ni	Mo	S	Cr	P
	0.65-1.00	0.03max	0.75max	1.50-2.20	11.00-14.00	2.00-3.00	0.03max	18.00-20.00	0.03max

## TYPICAL MECHANICAL PROPERTIES

### Typical as welded

Yield Strength	≤350MPa
Tensile strength	≤510 MPa
Elongation	≤30%
Impact Energy ASO-V(J) 20°C	≥47

## WELDING CURRENT

DCEN (-)

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  
LR  
TUV  
DB

**STORAGE**

Store all TIG filler rods 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	Length	Part Number / Order code
0.9mm	5kg	1000mm	VR88509105
1.2mm	5kg	1000mm	VR88512105
1.6mm	5kg	1000mm	VR88516105
2.0mm	5kg	1000mm	VR88520105
2.4mm	5kg	1000mm	VR88524105

All rods are embossed for ease of identification.

