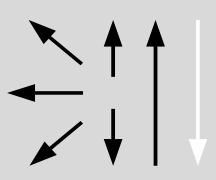


Classification							
AWS A5.4		EN ISO 3581-A			GB/T 983		
E316L-16		E 19 12 3 L R			E316L-16		
Characteristics and typical fields of application							
Cr-Ni-Mo rutile stainless steel electrode with excellent weldability and smoother bead surface. Weld metal features a good resistance against intergranular corrosion (IGC ASTM A262 Practice E)							
Base Materials							
ASTM 316 - 316L-S31653; SS 2343-2353-2375; BS316S33,316S13							
Typical analysis of all weld metal (Wt.-%)							
C	Si	Mn	Cr	Ni	Mo	Cu	N
0,02	0,75	0,55	18,8	12	2,55	0,04	0,07
Ferrite Number \approx 3-10 FN WRC 92							
Mechanical properties of the weld metal							
Heat Treatment	Yield strength	Tensile strength	Elongation	Impact work			
	R_e N/mm ²	R_m N/mm ²	($L_0=4d_0$)	ISO-V K_V (J)			
	MPa	MPa	%	+20°C	-40°C		
As Welded	430 (\geq 320)	575 (\geq 510)	40(\geq 30)	65(\geq 47)	45 (\geq 34)		
Operating Data							
		Polarity DC (+) / AC	Interpass temperature : 150°C Heat Input: Max. 2.0 KJ/mm Re-drying for 2 h at 250 – 280°C				
Approval							
ABS, CWB, CE							
Size, Packing and Recommended welding parameters							
Size (mm)	Kg / Pack		Kg / Box		Amperage (A)		
2.50 x 350	5,00		15,00		50-80		
3.25 x 350	5,00		15,00		80-120		
4.00 x 350	5,00		15,00		100-160		
5.00 x 450	5,00		15,00		160-220		