Selectarc Inox 316HB

Basic type HC

Stainless Steel Electrode

Classification

AWS A5.4 : E316H-15 EN 1600 : E 19 12 2 B 4 2

ISO 3581-A : E 19 12 2 B 4 2

Description & Applications

Basic coated Mo containing austenitic stainless steel electrode with increased carbon and approx. 5% ferrite. Stable arc, easy to watch weld pool, good slag removal, regular weld beads. Good behaviour in positional welding and on bad prepared joints. Designed for high temperature service up to 750°C to weld 17/12/2 (316H) stainless steels as well as stabilised grades.

Main applications: Petrochemical industries, tubes, heat exchangers, piping systems.

Base materials

Stainless steels for general use:

UNS	Alloy	EN 10088	Mat. N°
S31600	316	X5CrNiMo17 12 2	1.4401
S31609	316H	X6CrNiMoN17 12 2	1.4919
S31635	316Ti	X10CrNiMoTi18 12	1.4573
S31640	316Cb	X6NiCrMoNb17 12 2	1.4580
J92920	316H		

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Fe
0.05	0.4	1.5	18.5	11.5	2.2	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
>380	>560	>35	+20°C >80

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x350
Current	(A)	70	90	120

Redrying at 250°C during 1 hour, if necessary. Interpass temperature : < 150°C.

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