



Selectarc Inox 316MnNB

Basic Type, Fully Austenitic
Stainless Steel Electrode

Classification

AWS A5.4 : E316LMn-15 EN 1600 : E 20 16 3 Mn N L B 4 2
ISO 3581-A : E 20 16 3 Mn N L B 4 2

Description & Applications

Basic coated and fully austenitic stainless steel electrode containing low Carbon, Molybdenum and Nitrogen. The deposit is highly corrosion resistant in seawater and to nitric acid. Wet corrosion resistant up to 350°C.

Stable arc, easy to watch weld pool, medium slag removal, regular weld beads.

Main applications: Used in Urea Plants and for cryogenic 3.5-5% Ni steels.

Base materials:

EN	Material N°
X2CrNiMoN18-14-3	1.3952
X2CrNiMoN17-11-2	1.4406
X2CrNiMoN18-13-3	1.4428
X2CrNiMoN17-13-3	1.4429
X2CrNiMo18-14-3	1.4435

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	N	P	S	Fe
0.03	0.5	5.8	18.5	15.8	2.7	0.15	0.15	<0.020	<0.015	Rem.

All Weld Metal Mechanical Properties

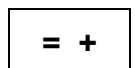
R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
450	620	30	+20°C 80 -196°C 45

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x350
Current	(A)	70-80	90-100	110-130

Redrying at 250-300°C during 1h, if necessary. Interpass temperature : < 150°C.

FT En-1409



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