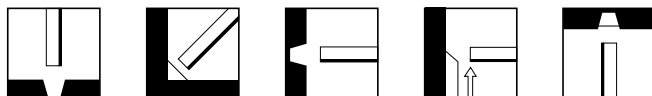


Classifications

EN 1600:1997	: E 19 12 3 L R 12	KS D 7014	: E316L-16
AWS A5.4-06	: E316L-16	JIS Z 3221	: ES316L-16

Description

- Covering is lime titania type for welding of 18%Cr-12%Ni-Mo stainless steel. (AISI 316) or dissimilar steels.
- Especially suitable for flat and horizontal fillet welding.
- Excellent corrosion resistance against sulphurous acid, phosphoric acid and acetic acid.
- Redry the electrode at 250~350°C for 30~60 minutes prior to use.

Welding positions**Typical chemical composition of all-weld metal (%)**

C	Si	Mn	P	S	Ni	Cr	Mo	Cu
0.03	0.72	1.08	0.028	0.013	12.5	18.4	2.5	0.3

Typical mechanical properties of all-weld metal

	Y.S (0.2%OS) (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.4		min. 490	min. 30	
EN 1600	min. 320	min. 510	min. 25	
Example	440	570	43	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.0	2.6	3.2	4.0	5.0
Length	(mm)	250	350	350	350	350
Amp. (A)	F V · OH	40~50 35~45	55~70 45~60	80~110 70~90	120~150 90~130	140~180 -

Approvals

ABS	BV	DNV	GL	KR	LR
E316L-16	UP	316L	4435	RD316L	316Lm

* Others : CWB, TÜV, CE