

E316L-16

AWS A5.4 E316L-16
ISO3581-A-E19 12 3 LR
GB/T 983 E316L-16

Description:

A super-low carbon stainless steel electrode designed to weld Cr18Ni12Mo2 steels .With excellent operation and processing properties. The deposited metal carbon content is $\leq 0.04\%$, so the heat resistance, corrosion resistance and crack resistance performance is excellent. Used to weld 06Cr18Ni12Mo2 type steel, dissimilar steels and high chromium steel which can not be heat treatment after welding.

Welding Position:



Diameters:

2.5mm, 3.2mm, 4.0mm, 5.0mm.

Typical Mechanical Properties:

Tensile strength(MPa):	620
Yield strength(MPa):	--
Elongation(%):	37

Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	Cu
0.021	0.65	0.02	0.005	0.62	12.75	19.22	2.23	0.25

Welding Current:(AC/DC \pm)

Diameter(mm)	2.5	3.2	4.0	5.0	
Current/A	F/H	60-80	80-120	100-150	140-180
Current/A	V/OH	40-70	60-100	80-130	-

Note:

- 1.The electrodes should be baked 1 hours in 300-350 $^{\circ}$ C before using.
- 2.Welding in short arc,and swing scope should not excess 2.5 times of the electrode diameter.