



STAINLESS STEEL WELDING ELECTRODE

AWS E316L-16

DESCRIPTION:

- a.E316L-16 is a lime titanium type ultralow carbon electrode for stainless steel.Both AC and DC can be applied.The weld seam metal shows excellent mechanical properties and has good resistibility to intergranular.
- b.It can be used for all position welding with excellent performances:stable arc,small spatters,good appearance of weld.And also the welding electrode shows good heat resistance character,not easy to turn red and gas porosity is not produced.

APPLICATION:

Suitable for welding the parts of chemical industry and power engineering,such as A1S1 316 steel,SUS 316 steel,etc.

ATTENTION:

- a. Before welding,the welding electrodes should be baked at the temperature from300-350°C for one hour.
- b. The stainless steel brush must be used to clean the weld seam,in order to avoid iron filings penetrating there to affect its quality.

Chemical Composition of Deposited Metal: (%)

	C	Mn	Si	P	S	Cr	Ni	Mo
Standard	0.025	0.93	0.64	0.015	0.010	18.7	11.40	2.50
Typical	≤0.04	0.5-2.5	≤0.90	≤0.040	≤0.030	17.0-20.0	11.0-14.0	2.0-3.0

Mechanical Properties of Deposited Metal

	Tensile Strength σb(Mpa)	Elongation δ5 (%)
Standard	560	41
Typical	≥490	≥30

Recommended Current(AC or DC*)

Size(mm)	Φ2.5×350	Φ3.2×350	Φ4.0×400	Φ5.0×400
Current(A)	50-85	80-120	100-150	140-180
Vertical,Overhead Current(A)	45-80	70-110	90-135	-