

SMAW**For Stainless Steel****STAINARC 316L**

CLASSIFICATION : AWS A5.4 E316L-16

JIS Z3221 D316L-16

WELDING POSITIONS :



- Rutile / Moisture Resistance Coating
- All Positional, Low C Deposit
- For The Critical Welding Of Type 316 and 316L Stainless Steels

DESCRIPTION AND APPLICATIONS

New generation STAINARC 316L is an extra low carbon, rutile type electrode exhibiting superior all positional (except vertical down) performance with an improved moisture resistant coating for weld metal of high radiographic integrity. The smooth arc action of STAINARC 316L together with low spatter and excellent slag control/detachability promote exceptional weld appearance and profile. Other features include high arc stability and easy restriking.

STAINARC 316L deposits Molybdenum bearing, 19% Cr / 12% Ni / 2.3% Mo filler metal to meet the requirements for welding AISI type 316 and 316L stainless steel in critical applications.

STAINARC 316L is also recommended for the general purpose welding of common 300 series stainless steels such as 301, 302, 304 and 304L.

TYPICAL ALL WELD METAL COMPOSITION (Wt%)

C	Mn	Si	Cr	Ni	Mo
0.025	0.7	0.7	18.5	12.0	2.3

FERRITE NUMBER**3.0 - 7.5 FN***

* using Sevens Gauge

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES•

YIELD STRESS	TENSILE STRENGTH	ELONGATION	CVN IMPACT VALUES
400 N/mm ²	610 N/mm ²	38%	75J @ - 20°C

• in "as welded" condition.

OPERATIONAL AND PACKAGING DATA

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE • (amps)	PACKAGING (kg)		
			PKT		CTN
2.0	300	30 - 50	2	4	20
2.6	300	50 - 75	2.5	5	20
3.2	350	75 - 110	2.5	5	20
4.0	350	110 - 150	2.5	5	20

- Recommended for DC + or AC (minimum 45 OCV) operation

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