SUNWELD 316L

Stainless Steel Electrode

CLASSIFICATION

AWS A 5.4 : E 316 L-16
IS 5206-83 : E19.12.2 LR 26

CHARACTERISTICS

SUNWELD 316 L is a stainless steel electrode depositing an extra low carbon 18% Cr, 12 % Ni and 2.8 % Mo stainless steel weld metal. The weld metal has excellent resistance to inter-granular corrosion even at elevated temperatures.

Special Characteristic: Delta Ferrite 5 to 10 FN

APPLICATIONS

Ideally suited for welding of 18/13/Mo type steels corresponding to AISI 316 & 316L,317 type stainless steels used in chemical tanks paper mill equipment, bleaching equipment, chemicals plats, textile plants whose vessel furnaces are exposed to severe corrosion by acids etc.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

C	Mn	Si	Cr	Ni	Mo	S	P
0.031	1.10	0.47	19.10	12.50	2.42	0.014	0.020

MECHANICAL PROPERTIES OF ALL WELD METAL (TYPICAL)

Ultimate Tensile Strength	Elongation
574.0 N/mm^2	38.4 %

CURRENT RANGE & PACKING DATA:

Size (mm)	Length (mm)	Current(Amp) AC or DC(+)	Quantity of Electrodes in a Carton	Quantity of Electrodes in a Cardboard box
2.50	350	60-80	2 Kg	10 Kg
3.15	450	80-100	2 Kg	10 Kg
4.00	450	100-140	2 Kg	10 Kg
5.00	450	140-180	2 Kg	10 Kg

RECOMMENDATIONS:

Re-dry the electrodes at 200°C for one hour. Use stainless steel wire brush for cleaning the welds.