

Meltolit

316L E

AWS A 5.4: E316L-16 ISO 3581-A: E 19 12 3 L R 32

DESCRIPTION

Low carbon Rutile-basic-coated Mo containing austenitic stainless steel electrode with approx. 8% ferrite. Coating with very low moisture pick-up. Soft fusion without spatters, very easy slag removal, exceptional bead appearance, easy restriking. For welding and cladding on austenitic Cr-Ni-Mo stainless steels and clad plates. Applied for service temperatures from -120°C up to +400°C in the chemical and petrochemical industries, in refineries, in the food industries and for ship building to weld pipes, tanks, heat exchangers.

WELDING POSITIONS



CURRENT

DC+/AC

COATING

Rutile-Basic

MATERIAL

316, 316L, 316Cb, 316Ti

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A5</i> (%)	<i>KV(j)</i>
600	490	32	-20°C - 55 -120°C - 45

WELD METAL COMPOSITION(%)

C	Mn	Si	Cr	Mo	Ni
0,02	0,7	0,8	18,5	2,7	12,0

PACKAGING & WELDING PARAMETERS

Dimension(mm)	1,6 x 300	2,0x300	2,5 x 300	3,2 x 350	4,0 x 350
Current(A)	30-45	35-60	40-80	80-120	90-190
Volt(V)	29	29	29	29	30

EQUIVALENT FILLER METALS

TIG	Meltolit 316LSi XT
MAG	Meltolit 316LSi XM
FCW	Meltolit 316L FCW

Redrying if necessary for 2 hours in 300°C.