

Classification : AWS A5.4 : E316L-16

EN 1600 : E 19 12 3 L R 32

ISO 3581-A : E 19 12 3 L R 32

Properties & Applications :

Rutilo-basic electrode depositing an austenitic molybdenum steel with an average ferrite content of 8% and very low carbon content. Coating with very low moisture recovery, soft fusion without projection, good detachment of the slag, very nice appearance of the cord, easy re-priming. Used for welding and recharging unstabilized Cr/Ni/Mo austenitic stainless steels and similarly chemically resistant plated steels in the form of solutions or gases (up to 550°C). Service temperature in a liquid corrosive environment: from -120°C to 400°C. Excellent corrosion resistance in seawater. Chemical, petrochemical and marine industries, refineries, repairs, pipes, heat exchangers, food industries...

Shades of weldable steel :

General use of Stainless Steel :

UNS	Steel	EN 10088	N° of Ally	UGINE
S31600	316	X5CrNiMo17-12-2	1.4401	UGINOX 17-10 M
S31603	316L	X2CrNiMo17-12-2	1.4404	UGINOX 18-11 ML
J92900		G-X5CrNiMo19 11 2	1.4408	
S31635	316Ti	X6CrNiMoTi17-12-2	1.4571	UGINOX 17-11 MT
S31635	316Ti	X10CrNiMoTi18-12	1.4573	
S31640	316Cb	X6NiCrMoNb17-12-2	1.4580	
		G-X5CrNiMoNb19-11-2	1.4581	

Analyse of metal deposit (%) :

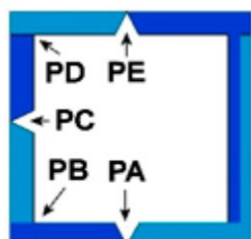
C	Si	Mn	Cr	Ni	Mo
<0.03	0.8	0.7	18.5	12	2.7

Mechanical characteristics of metal deposit :

Re (MPa)	Rm (MPa)	A ₅ (%)	KV (J)
>400	>560	>35	+20° C > 70 -120° C > 40

Average Intensities - Conditions of Employment :

Electrode	øxL (mm)	1,6x250	2,0x300	2,5x300	3,2x350	4,0x350	5,0x450
Intensity	(A)	30	45	70	100	135	180



Temperature max between the passes : 200°C. Heating 1 heure à 250°C if necessary.

Welding position :

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