316L

SPECIAL WELDING ROD FOR STEEL TYPE AISI-316. ITS MOLYBDENUM CONTENT INCREASES CORROSION RESISTANCE TO ORGANIC ACIDS.

CLASSIFICATION A.W.S: E-316L-16

APPLICATIONS: To weld tanks and vessels in the chemical industry, in the paper industry and in the food processing industry. To weld in chemical mixing equipment, hydraulic turbines, heat exchangers, pipes, heat resistant cast metal parts, valves and evaporators. To weld pressure vessels, chemical mixers and stirring equipment, combustion chambers, paper processing tanks, laundry equipment, bakery equipment, salt processing equipment, etc.

CHARACTERISTICS AND PROCEDURE: 316L is a stabilized stainless steel welding rod with a low carbon content. It is ideal to weld acid resistant steel in the chemical industry. The filler metal is austenitic stainless steel with 2.7% Molybdenum, rated as Type AISI-316. This electrode is suitable to weld stainless steel types 301, 302, 304, 308, 410 and 430. It withstands inter crystalline corrosion up to 400° C. Slag is easily removed once the filler metal cools down-- it peels off. Clean the joint area to remove dirt, scales, grease and rust. When using DC, connect the welding rod holder to the positive pole-- i.e. Use reverse polarity. Keep the arc short and tilt the electrode slightly in the same direction as the weld. Remove the slag between one pass and the next.

TENSILE RESISTANCE:	5,500 KG./CM2 (78,000 PSI)
BRINELL HARDNESS:	190 BHN
ELONGATION:	40%
FERRITE No.:	0
POSITIONS: :	ALL
CURRENT:	AC or DC REVERSE POLARITY

FILLER METAL CHEMICAL ANALYSIS %						SIZES	AMPERAGE
C	**Mn**	**Si**	**Cr**	**Ni**	**Mo**	2.38 mm-3/32"	50-70
0.02	1.70	0.90	19.5	10.5	2.80	3.25 mm - 1/8"	80-100
						4.0 mm - 5/32"	110-130
						5.0 mm - 3/16"	140-170