

Classification

AWS A5.4

EN 1600

E316L-16

E 19 12 3 NL R 1 2

Characteristics and typical fields of application

Rutile electrode and is noted for its superior welding characteristic and metallurgy. Other characteristic include high current carrying capacity, minimum spatter formation, self-releasing slag, smooth and clean weld profile, safety against formation of porosity due to moisture resistant coating and packaging into hermetically sealed tins. Resistant to inter granular corrosion (ASTM A262 Practice E).

Base Materials

ASTM 316 - 316L-S31653; SS 2343-2353-2375; BS316S33,316S13

Typical analysis of solid wire (wt.-%)

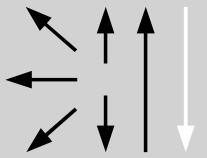
C	Si	Mn	Cr	Ni	Mo
0.02	0.70	0.80	18.0	13.0	2.20

Ferrite Range \approx 3 – 8 FN (WRC92)

Mechanical properties of all-weld metal

Heattreat-ment	Yield strength R_e N/mm ²	Tensile strength R_m N/mm ²	Elongation ($L_0=5d_0$)	Impact work ISO-V KV J	
	MPa	MPa	%	+ 20 °C	-120 °C
As Welded	430	575	33	73	45

Operating data

	Polarity DCEP/AC	Scaling Temperature : Approx. 850°C
		Interpass temperature : 150°C
		Heat Input: Max. 2.0 KJ/mm
		Rebaking for 3 h at 250 – 280°C
		Electrode Identification : Bohler Fox S 316L-16

Approvals

ABS

Size, Packaging and Electrical Operating Data

Size mm	Kg / Pack	Kg / Box	Amperage (A)
2.50 × 300	3.63	10.89	50-75
3.25 × 350	4.10	12.30	70-110
4.00 × 350	4.10	12.30	100-150