

Coated Electrode for Stainless Steels

Classification

EN ISO 3581-A : E 19 12 3 LR 12

AWS A5.4 : E316L-17

General Description

AS P-316L-17 is an extra low carbon rutile coated electrode. It gives Cr-Ni-Mo type filler metal. Excellent quality smooth weld beads are highly resistant to acids and to intergranular corrosion at operating temperatures up to 350°C and to oxidation up to 800°C. The excellent side wall wetting characteristic, no undercut and very fine ripple minimize crevice corrosion and grinding time. This is particularly useful in the food and drink industry where a smooth polished surface (mirror like bead appearance) is required. It gives a stable arc and the slag is easy to remove.

Chemical Composition (w%), Typical, All Weld Metal

C	Si	Mn	Cr	Ni	Mo
0.03	1.00	0.80	17	11	2.9

Mechanical Properties, Typical, All Weld Metal

Yield Strength : 490 N/mm²
 Tensile Strength : 600 N/mm²
 Elongation (L=5d) : 35 %
 Impact (ISO-V) : 60 J (+20°C)

Applications and Materials to be Welded

AS P-316L-17 can be used in the welding of pipes, tanks and vessels that are used in chemical, paint and paper industries. Cr-Ni- Mo steels, steel cast parts and pipes that are used for acid, gas and vapor transmission can also be welded with this electrode. AS P-316L-17 can also be used in the build up welding of leakproof surfaces.

	EN 10088-1/-2	EN 10213-4	W. Nr.
Extra Low Carbon Stainless Steels (C < %0.03)	X2 CrNiMo 17 12 2	-	1.4404
	X2 CrNiMo 18 14 3	-	1.4435
	X2 CrNiMoN 17 11 2	-	1.4406
	X2 CrNiMoN 17 13 3	-	1.4429
Medium Carbon Stainless Steels (C > %0.03)	X4 CrNiMo 17 12 2	-	1.4401
	X4 CrNiMo 17 13 3	-	1.4436
	-	G-X5 CrNiMo 19 11	1.4408
Stabilized Stainless Steels (Nb/Ti)	X6 CrNiMoTi 17 12 2	-	1.4571
	X6 CrNiMoNb 17 12 2	-	1.4580
	X6 CrNiNb 18 10	-	1.4550
	-	G-X5 CrNiNb 19 10	1.4552




AS P-316L-17



Coated Electrode for Stainless Steels

Welding Parameters / Packing and Diameter Informations / Welding Positions

Current Type and Polarity : AC min 50 V ; DC (+)

Diameter [mm]	Length [mm]	Current [A]	Electrode Weight [g/100 pcs]	Box Weight [kg] Quantity [pcs/box]	Export Box Box Weight [kg]			
2.00	250	40 - 60	930	1.6 / 175	1.5	1G/PA	2F/PB	2G/PC
2.50	250	50 - 80	1620	1.6 / 100	1.5			
2.50	300	50 - 80	1620	1.6 / 100	1.5			
2.50	350	50 - 80	1620	1.6 / 100	1.5			
3.25	300	80 - 120	2940	1.9 / 65	2.0			
3.25	350	80 - 120	2940	1.9 / 65	2.0			
4.00	350	100 - 145	4920	2.0 / 40	2.5			
4.00	350	150 - 190	8660	2.5 / 29	2.5			

