

## Premium Stainless Steel Arc Welding Electrodes

- All Positional Except Vertical Down Rutile Type
- High Crack Resistance
- Stainless Steel to Dissimilar Steel

316L-16 is a high quality rutile type all positional stainless steel welding electrode. With extra smooth running and high arc stability. The extra low carbon is suitable for general purpose welding of the most common 300 series stainless alloys which are corrosion resistant and can also be used for some ferric type alloys. This electrode has a good strike and re-striking capability and gives a regular bead appearance with excellent slag removal.

### TYPICAL CHEMICAL COMPOSITION OF DEPOSITED METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.03	0.70	1.25	0.024	0.011	18.70	12.40	2.65

### Current Type: AC or DC+

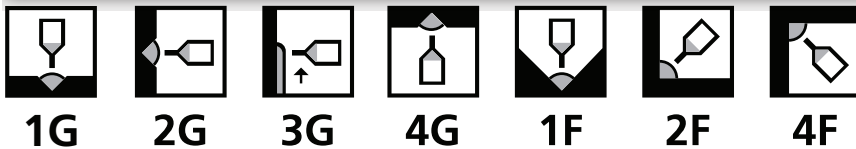
DIAMETER/LENGTH(mm)	2.5/350	3.2/350	4.0/350
Positions	Current(A)	Current(A)	Current(A)
F	55-70	80-100	110-140
V/OH	45-65	70-90	100-130

### TYPICAL MECHANICAL PROPERTIES OF DEPOSITED METAL

Tensile Strength 560 MPa    Elongation 46%

### WELDING POSITIONS

All Positional Except Vertical Down



### CLASSIFICATION

AWS: A5.4 E316L-16

AS/NZS: 4854-B - E316L-16

EN ISO: E 19 12 2 LR 26

Recommended for DC +/- or AC (minimum 50 OCV) Voltage is determined by arc current and electrode arc length. Arc voltage shown is typical and is only to be used as a guide.

**KEEP DRY** Re-Drying/Conditioning temperatures of 200-250°C for 1 hour. Re-drying should be restricted to a maximum of three cycles.

### Warning:

- Electric shock can kill
- Always wear eye protection
- Protect yourself and others around you
- Use enough ventilation for both arc and fume source
- Fumes and gases are dangerous to your health
- Arc rays can injure your eyes and burn skin