

**Stainless steel
 Rutile type electrode**

SUPER STAINLESS 316

Classification **AWS A 5.4:** E 316- 16
 DIN EN 1600: E 19 12 3 R 32

DIN 8556: E 19 12 3 R 23
Werkstoff Nr: 1.4430 P

Description and applications

Rutile-basic-coated Mo containing austenitic stainless steel electrode with approx 6 to 8% ferrite. Coating with very low moisture pick-up. Soft fusion, without spatters, very easy slag removal, exceptional bead appearance, easy restriking.
 For welding and cladding on austenitic Cr-Ni-Mo stainless steels and clad plates. Applied for service temperatures from -120°C up to +400° C in the chemical and petrochemical industries, in refineries, in the food industries and for ship building to weld pipes, tanks, heat exchangers...

Base materials

Stainless steels for general use:				
UNS	Alloy	EN 10088	Material N ^a	UGINE
S31600	316	X5CrNiMo17-12-2	1.4401	UGINOX 17-10 M
J92900		G-X5CrNiMo19112	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-X5CrNiMoNb19-11-12	1.4581	

All weld metal mechanical properties (typical)

Tensile Strength R _m (N/Mm ²)	Elongation %	ISO- V J RT
590	39	60

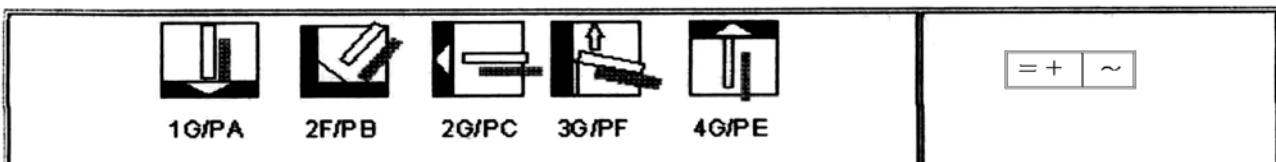
Typical weld metal Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	S	P
0.05	0.80	0.80	17.60	11.20	2.30	0.015	0.030

Amperes (A)

2.50	3.15	4.00	5.00
50-80	80-110	110-150	150-180

Welding instruction Redrying 1 h at 250° C if necessary. Interpass temperature: <200°C.



Updated On: 10/12/2008