S-316.16N

Type : Rutile

Conformances

AWS A5.4/ ASME SFA5.4 E316-16
JIS Z3221 ES316-16
EN ISO 3581-A-E 19 12 3 R
KR RD316
ABS AWS A5.4 E316-16
BV UP (E316-16, -20°C)
DNV·GL NV 316

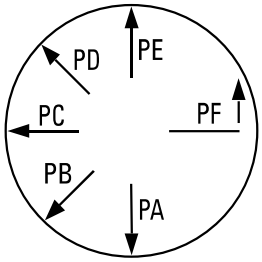
Applications

- Stainless steel (18%Cr-12%Ni-2%Mo)

Features

- Good resistance to corrosion and oxidizing environments
- Good heat resistance
- asy to remove slag
- Low spatter

Welding Position



Current

AC or DC ±

Redrying Conditions

350°C (662°F) X 1hr

Diameter / Packaging

Diameter	Length	P.V.C	
mm (in)	mm (in)	packet	carton
		2.5kg(5.5lbs)	10kg(22lbs)
2.6 (3/32)	350 (14)	√	
3.2 (1/8)	350 (14)	√	
4.0 (5/32)	400 (16)	√	
5.0 (3/16)	400 (16)	√	
6.0 (15/64)	450 (18)	√	

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.03	0.77	0.9	0.03	0.029	18.7	12.3	2.5

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in²)	EL (%)
572 (83,100)	40.8

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	2.0 (5/64)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	300 (12)	300 (12)	350 (14)	350 (14)	350 (14)
F & HF	25~55	50~85	70~115	95~145	135~180
V-up, OH	20~50	45~80	65~110	85~135	-