

# S-316L.16N[17]

Type : Rutile, Rutile-acid



## Conformances

AWS	A5.4/ ASME SFA5.4 E316L-16	BV	UP (E316L-16, -20°C)
JIS	Z3221 ES316L-16 / EN ISO 3581-A-E 19 12 3 L R	DNV-GL	NV 316L
AWS	A5.4 / ASME SFA5.4 E316L-17	NK	KD316L
JIS	Z3221 ES316L-17 / EN ISO 3581-A-E 19 12 3 L R	CWB	CSA W48 E316L-16
KR	RD316L	TÜV	EN ISO 3581-A-E 19 12 3 L R
ABS	AWS A5.4 E316L-16	DB	EN ISO 3581-A-E 19 12 3 L R
	AWS A5.4 E316L-17	CE	
LR	316L	CCS	316L

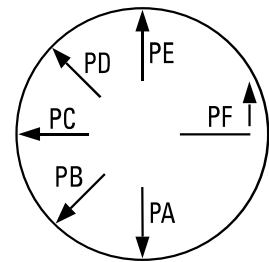
## Applications

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

## Features

- Good resistance to corrosion and oxidizing environments
- Good heat resistance
- Easy to remove slag
- High moisture resistance (17 type)

## Welding Position



## Current

AC or DC ±

## Redrying Conditions

350°C (662°F) X 1hr

## Diameter / Packaging

Diameter	Length	Standard		Vacuum				P.V.C	
		packet	carton	packet	carton	packet	carton	packet	carton
mm (in)	mm (in)	5kg(11lbs)	20kg(44lbs)	1.5kg(3.3lbs)	15kg(3.3lbs)	5kg(11lbs)	20kg(44lbs)	2.5kg(11lbs)	10kg(22lbs)
2.0 (5/64)	300 (12)								✓
2.6 (3/32)	300 (12)								✓
3.2 (1/8)	350 (14)								✓
4.0 (5/32)	350 (14)								✓
5.0 (3/16)	350 (14)								✓

SMAW

SAW

GMW

GTAW

FCW

Non-FERROUS

APPENDIX

**Typical Chemical Composition of All-Weld Metal (%)**

Product name	C	Si	Mn	Cr	Ni	Mo
S-316L.16N	0.02	0.75	0.95	18.5	12.7	2.7
S-316L.17	0.02	0.60	1.15	23.1	12.1	2.5

**Typical Mechanical Properties of All-Weld Metal**

Product name	TS MPa(lbs/in <sup>2</sup> )	EL (%)
S-316L.16N	557 (80,900)	45.2
S-316L.17	560 (81,300)	48.0

**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	-