

S-316LT.16

Type : Basic

Conformances

AWS A5.4/ ASME SFA5.4 E316L-16

JIS Z3221 ES316L-16

EN ISO 3581-A-E 19 12 3 L R

ABS AWS A5.4 E316L-16 (-196°C)

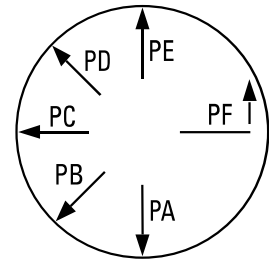
Applications

- Stainless steel (18%Cr-12%Ni-2%Mo)
- LPG, LNG storage tank

Features

- Good impact value up to -196°C
- Good resistance to inter-crystalline corrosion
- Easy to remove slag
- Low spatter

Welding Position



Current

AC or DC ±

Redrying Conditions

350°C (662°F) X 1hr

Diameter / Packaging

Diameter mm (in)	Length mm (in)	P.V.C	
		packet 2.5kg(5.5lbs)	carton 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
0.035	0.55	1.59	0.021	0.016	18.5	13.5	2.5

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)
570 (82,700)	40.6	-196 (-321)	36 (27)

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	-

SMW

SAW

GMW

GTW

FCW

Non-FERROUS

APPENDIX