



EI 316L

Coated Electrode for Stainless Steels -

Standards

AWS/ASME SFA - 5.4	E316L-16
EN ISO 3581 - A	E 19 12 3 L R 32
TS EN ISO 3581 - A	E 19 12 3 L R 32

Properties and Applications

Rutile type stainless steel electrode for welding austenitic stainless Cr-Ni-Mo steels or cast steels, having an extra low carbon content. For operating temperatures of up to +400°C. Especially suitable for welding of stainless steel chemical tanks and pipes in chemical, textile, paint, paper industries. Possible to use equally well both with AC and DC. Easy arc striking and re-striking. Fine metal droplet transfer, good fusion of joint faces, finely rippled bead surface, easily removable slag.

Approvals & Certificates

BV TSE	CWB TUV	DNV-GL CE
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Materials

EN	Material	ASTM
X3CrNiMo17-13-3	1.4436	316
X5CrNiMo17-12-2	1.4401	316
GX2CrNiMo19-11-2	1.4409	
X2CrNiMo17-12-2	1.4404	316L
GX5CrNiMo19-11-2	1.4408	CF-8M
X2CrNiMo18-14-3	1.4435	316L
X6CrNiMoTi17-12-2	1.4571	316 Ti
X6CrNiMoNb17-12-2	1.4580	316 Cb
G-X5CrNiMoNb19-11-2	1.4581	
X10CrNiMo18-12	1.4583	318

Typical Chemical Values of Weld Metal

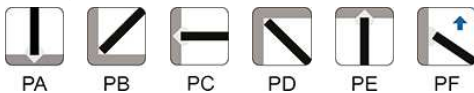
Type of Analysis	C	Si	Mn	Cr	Ni	Mo
Weld Deposit	0.03	0.80	0.90	19.00	12.00	2.50

Typical Mechanical Values of Weld Metal

Test Condition	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	600	37	20°C → 70

Application Information

Welding Positions



Polarity:



Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
2.00x250	50-70
2.00x300	40-60
2.50x250	50-80
2.50x300	50-80
3.25x300	80-120
3.25x350	80-120
4.00x350	100-165
5.00x350	140-220



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