

# 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 LR  
 ABS AWS A5.4 E316L-16 (-196°C)

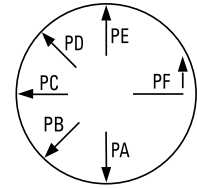
## Applications

- 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 1 hr

## Diameter / Packaging

Diameter	Length	P.V.C	
		packet	carton
mm (in)	mm (in)	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
0.035	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 <sup>2</sup> )	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	-

SMAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX