Selectarc Inox 316NG

Basic type Stainless Steel Electrode

Classification

AWS A5.4 : E316L-15 EN 1600 : E 19 12 3 L B 4 2
ISO 3581-A : E 19 12 3 L B 4 2

Description & Applications

Low carbon basic coated Mo- containing austenitic stainless steel electrode with approx. 8% ferrite. Stable arc, easy to watch weld pool, good slag removal, regular weld beads. Good behaviour in positional welding and on bad prepared joints. Excellent mechanical properties. For welding and cladding on austenitic Cr-Ni-Mo stainless steels and clad plates. Applied for service temperatures from -196°C up to +400°C in the chemical and petrochemical industries, in refineries and for ship building to weld pipes, tanks, heat exchangers...

Base materials

Stainless steels for general use:

UNS	Alloy	EN 10088	Mat. N°	UGINE
S31600	316	X5CrNiMo17 12 2	1.4401	UGINOX 17-10 M
S31603	316L	X2CrNiMo17 12 2	1.4404	UGINOX 18-11 ML
S31651	316LN	X2CrNiMoN17 12 2	1.4406	
J92900		G-X5CrNiMo19 11 2	1.4408	
S31635	316Ti	X6CrNiMoTi1712 2	1.4571	UGINOX 17-11 MT
S31635	316Ti	X10CrNiMoTi18 12	1.4573	
S31640	316Cb	X6NiCrMoNb17 12 2	1.4580	
		G-X5CrNiMoNb19 11 2	1.4581	

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Fe
<0.04	0.4	1.6	18.0	12.0	2.7	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
>380	>560	>35	+20°C >80 -120°C >50

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x350
Current	(A)	70	90	120

Redrying at 250°C during 1 hour, if necessary. Interpass temperature : < 150°C.
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