

ROWELD 316L

EXTRA LOW CARBON, RUTILE COATED 18/12/2.3 MO
STAINLESS STEEL ELECTRODE

BASIC ALLOY: FE, CR, NI, MO
AWS/SFA-5.4: E 316L-16
EN ISO 3581-A E 19 12 3 R 32

KEY FEATURES:

An extra low carbon, rutile coated 18/12/2.3 Mo stainless steel electrode with excellent resistance to corrosion, heat and cracking. The weld metal has properties of creep resistance and is of radiographic quality with stable and smooth arc, easy slag detachability and almost spatter free welding

APPLICATIONS

- Suitable for AISI 316L and 317L grades of stainless steels.
- Chemical, dyes, paint, petrochemical, pharmaceutical and fertilizer industries.
- Commonly used in chemical tanks, paper mill equipment's, bleaching equipment.
- Chemical plants, textile plants.
- Suitable for welding titanium and Niobium stabilized 18-12 steels of the type SS 2344 & 2345 except when the corrosive conditions are severe

RE-DRY CONDITION:

- Re-Dry the electrode at 250°C for one hour before use.

CHEMICAL COMPOSITION:

| C | Mn | Si | S | P | Cr | Ni | Mo |
|-----------|-----------|----------|-----------|-----------|-------------|-------------|-----------|
| 0.04 max. | 0.50-2.50 | 1.00 Max | 0.030 Max | 0.040 Max | 17.00-20.00 | 11.00-14.00 | 2.00-3.00 |

MECHANICAL PROPERTIES:

| YS (N/mm ²) | UTS (N/mm ²) | EL % (l=5d) | CHARPY "V" NOTCH IMPACT @ |
|-------------------------|--------------------------|-------------|---------------------------|
| 330-450 | 430-560 | 22-30 | - 30C : 50-80 J |

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA

| Size (mm) (Dia) | Size (inch) (Dia) | Current Condition (DC+/ AC) Amps | Kg/pkt. | Kg/Case |
|-----------------|-------------------|----------------------------------|---------|---------|
| 2.50/ 2.40 | 3/ 32" | 50-80 | 2 | 10 |
| 3.15/ 3.20 | 1/ 8" | 80-100 | 2 | 10 |
| 4.00 | 5/ 32" | 110-140 | 2 | 10 |
| 5.00 | 3/ 16" | 140-170 | 2 | 10 |