

**AFROX 316L Class C5 Schedule K**



Afrox 316L Class C5 Schedule K is a rutile basic coated low carbon electrode for welding 19% Cr 12% Ni and 3% Mo type stainless steel, it has been specially formulated for applications requiring low temperature properties at -90°C for use in cryogenic applications. It is batch tested for tensile, charpy impact values and lateral expansion at -90°C.

**CLASSIFICATION**

AWS                      A5.4                      E316L-17

**CHEMICAL ANALYSIS (TYPICAL)**

% Carbon	0.030	% Chromium	18.900
% Manganese	0.720	% Molybdenum	2.550
% Silicon	0.730	% Nickel	12.600
% Sulphur	0.010	% Copper	0.050
% Phosphorous	0.010		

**TYPICAL MECHANICAL PROPERTIES  
(ALL WELD METAL IN THE AS WELDED  
CONDITION)**

	AC	DC
2% Proof Stress	517 MPa	513 MPa
Tensile Strength	596 MPa	601 MPa
Elongation %	39.0%	41.0%
Charpy V-Notch at -90°C	44J	39J
Lateral Expansion	0.30 mm	0.26 mm
Moisture Content	0.086%	0.086%

**PACKING DATA**

Diameter (mm)	Electrode Length (mm)	Current Amps	Item Number Multi-Kg pack	Pack Mass (Kg)
2.5	350	40 - 80	087-752	3 x 4
3.2	350	70 - 105	087-752	3 x 4
4.0	350	90 - 145	087-752	3 x 4

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