

AFROX 316L



Afrox 316L is a low carbon 19% chromium, 12% nickel and 3% molybdenum rutile basic coated electrode.. It is recommended for welding of low carbon molybdenum bearing steels of the AISI 316L type which may be used for applications such as pulp handling equipment, high temperature equipment, heat exchangers, chemical storage and transportation tanks, oil refining equipment and pharmaceutical equipment.

CLASSIFICATIONS

AWS	A5.4	E316L-17
SABS	1293	E19.12.3 LR 26
BS EN	1600	E 19 12 3 LR

APPROVALS

TUV (Kenblatt number 3244.00)
 South African Bureau of Standards (SABS 1293 and ISO 9001).

CHEMICAL ANALYSIS

% Carbon	0.03 max	% Nickel	11.0 - 14.0
% Manganese	0.5 - 2.5	% Molybdenum	2.5 - 3.0
% Silicon	0.90 max	% Sulphur	0.020 max
% Chromium	17.0 - 20.0	% Phosphorous	0.025 max

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

0,2% Proof Stress	430 MPa min
Tensile Strength	520 - 650 MPa
% Elongation on 4D	35 min
Charpy V-Notch at +20°C	50J min
Charpy V-Notch at -70°C	35J min

PACKING DATA

(DC+ AC 70 OCV min)

Diameter (mm)	Electrode Length (mm)	Current Amps	Item Number 4 Electrode Sleeve	Item Number 1 Kg Electrode Pack	Item Number Multi-Kg Pack	Pack Mass (Kg)
2	300	30 - 60	-	072-782	075-751	3 x 4
2.5	300	40 - 80	072-752	072-783	075-752	3 x 4
3.25	350	70 - 105	072-753	-	075-753	3 x 4
4	350	90 - 145	-	-	075-754	3 x 4
5	350	140 - 190	-	-	075-755	3 x 4

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