

SUPERWELD 316L



SUPERWELD 316L is a low carbon 19% chromium, 12% nickel and 2.5% 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-16
BS EN	1600	E 19 12 2 LR12

APPROVALS

TUV

CHEMICAL ANALYSIS

% Carbon	0.032	% Nickel	13.20
% Manganese	1.20	% Molybdenum	2.50
% Silicon	0.35	% Sulphur	0.010
% Chromium	19.50	% Phosphorous	0.016

**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 Multi-Kg Pack	Pack Mass (Kg)
2.5	300	50 - 85	085-752	3 x 5
3.25	350	80 - 120	085-753	3 x 5
4	350	100 - 150	085-754	3 x 5

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