

Stainless Steel SMAW Electrodes

G316

AWS A5.4 E316-16
JIS Z 3221 ES316-16

Product Features:

- Lime titanium oxide type covered electrode for 316 stainless steel, deposited weld metal contains approximately 18%Cr-12%Ni-2%Mo elements.
- Austenite structure weld metal, good heat, corrosion and crack resistance.
- Weld metal contains Mo element to get good crevice corrosion resistance.

Applications:

- Suitable for welding of severe acid and high heat resistance required SUS316 stainless steel.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	Ni	Cr	Mo	Fe
0.02	0.74	0.73	12.0	18.4	2.75	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %
489	594	36

Size (mm) & recommended welding parameters (A) AC or DC+

Diameter / Length	2.6/300	3.2/350	4.0/350	5.0/350
Flat position	60~85	85~120	110~150	150~200
Vertical / overhead position	50~75	75~105	95~120	----

Note:

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