

# Stainless Steel SMAW Electrodes

## G316L

AWS A5.4 E316L-16  
JIS Z 3221 ES316L-16  
ISO 3581-A-E 19 12 3 L R 1 2

### Product Features:

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

### Applications:

- Suitable for welding of severe acid and high heat resistance required SUS316L stainless steel.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	Ni	Cr	Mo	Fe
0.02	0.80	0.70	11.86	17.92	2.94	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation %
464	550	46

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

Diameter / Length	2.0/250	2.6/300	3.2/350	4.0/350	5.0/350
Flat position	30~50	60~85	85~120	110~150	150~200
Vertical / overhead position	30~50	50~70	75~105	95~130	----

### Note:

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