

SMAW Electrodes for Stainless Steel

G316H

AWS A5.4 E316H-16
JIS Z 3221 ES316H-16
ISO 3581-A-E 19 12 2 L R 1 2

Product Features:

- G316H has higher carbon content than G316L, which provides higher tensile and creep strengths at elevated temperatures.
- Lime-titania type electrode with 18%Cr-12%Ni-2.5%Mo deposited metal.
- Easy slag removal, good arc stability, less spatter loss and good bead appearance.
- Austenite with delta ferrite typically controlled in the range 3-8FN.

Applications:

- Suitable for welding of SUS316/316H base metal.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	Ni	Cr	Mo	Fe
0.04	0.92	0.77	12.0	18.8	2.73	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %
534	621	43

Size (mm) & recommended welding parameters (AC/DC+)

Diameter /Length	2.6/300	3.2/350	4.0/350	5.0/350
Flat position	60~85	85~120	115~150	150~200
Vertical /overhead position	50~70	75~105	95~120	----

Note:

- 250~300°C × 1 hr baking prior to use.
- Excessively wide weaving may cause welding defects. Keep weaving width less than 2.5 times of electrode diameter.

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