

# Stainless Steel SMAW Electrodes

## G316L-15

AWS A5.4 E316L-15  
JIS Z 3221 ES316L-15

### Product Features:

- Basic coating of stainless steel electrodes for 316 stainless steel has outstanding welding performance for vertical and overhead positions.
- Austenite weld metal contains adequate ferrite to obtain good heat, crack and corrosive resistance.
- Weld metal contains Mo element to get good crevice corrosive resistance.

### Applications:

- Suitable for welding of high acid and high resistance required SUS 316 and 316L.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	Ni	Cr	Mo
0.03	0.40	1.37	11.47	18.16	2.31

Typical mechanical properties of all weld metal

Tensile Strength N/mm <sup>2</sup>	Elongation %	FN
575	48.8	4

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	85~110	115~140	150~190
Vertical / overhead position	50~75	75~100	95~130	----

### Note:

- 250~300°C x 1hr baking prior to use.

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