

# E 316L-17

## STAINLESS STEEL STICK WELDING ELECTRODE

**Classification** : AWS: A5.4 E 316L-17

**Description** : An extra low carbon, lime titanium type stainless steel welding stick electrodes with 18Cr%,12Ni% & 2.30Mo% with excellent resistance to corrosion, heat and cracking. The weld metal creep resistance and radiography weld quality with stable and smooth arc, easy slag detachability and fine rippled weld bead with spatter free welding.

**Typical Application** :

- Fabrication welding job of 316 & 316L, ASTM A240 Type 316 & 316L
- Applications in pulp and paper industries
- Joining of austenitic stainless steel with molybdenum content
- Chemical equipment and textile industries

**Re-Dry Condition** : Re-Dry the electrode at 300°C for 1 hrs, for best results.

### ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Ni	Cr	S	P	Mo	Cu
0.040	0.5-2.5	1.0	11 – 14	17 – 20	0.030	0.040	2 – 3	0.75

(Single value maximum)

### ALL WELD MECHANICAL PROPERTIES:

YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	Elongation %	CHARPY “V” NOTCH IMPACT AT
>360	490 min.	30 min.	+20 <sup>0</sup> C : > 70 Joules

### DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm) (Dia)	Size (inch) (DXL)	Current Condition (DC+/AC 70V)	kg/pkt.	kg/Case
2.50/2.40	3/32”	50-80	2	10
3.15/3.20	1/8”	70-120	2	10
4.00	5/32”	100-140	2	10
5.00	3/32”	140-180	2	10

Tailor made packing available on request