

RATNA 316L

Extra low carbon, rutile coated 18/12/2.3 Mo stainless steel Electrode.

CLASSIFICATION : AWS/SFA-5.4: E 316L-16, DIN E 19.12.3 R23
IS-5206: E 19.12.2LR 26 , BS 19123LR

APPROVAL : LRA, TOYO, PDIL

CHARACTERISTICS : An extra low carbon, rutile coated 18/12/2.3 Mo stainless steel electrode with excellent resistance to corrosion, heat and cracking. The weld metal has properties of creep resistance and is of radiographic quality with stable and smooth arc, easy slag detachability and almost spatter free welding.

APPLICATION :

- 1) Suitable for AISI 316L and 317L grades of stainless steels.
- 2) Chemical, dyes, paint, petrochemical, pharmaceutical and fertilizer industries.
- 3) Commonly used in chemical tanks, paper mill equipments, bleaching equipment.
- 4) Chemical plants, textile plants.
- 5) Suitable for welding titanium and Niobium stabilized 18-12 steels of the type SS 2344 & 2345 except when the corrosive conditions are severe.

RE-DRY CONDITION : Re-Dry the electrode at 250°C for 1 hrs before use.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P	Cr	Ni	Mo
0.04 max.	0.50-2.50	1.00 Max	0.030 Max	0.040 Max	17.00-20.00	11.00-14.00	2.00-3.00

ALL WELD MECHANICAL PROPERTIES:

UTS (N/mm ²)	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT +20 ⁰ C : 60-80 J	FERRITE (FN)
520-660	30-42		3-10

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC+/AC) Amps	kg./pkt.	kg./Case
2.50/ 2.40 X 350	3/ 32" X 14"	60-80	2	20
3.15/ 3.20 X 350	1/ 8" X 14"	80-100	2	20
4.00 X 350	5/ 32" X 14"	110-140	2	20
5.00 X 350	3/ 16" X 14"	140-170	2	20

Customer packing on request.