

## RATNA 316LF

**Extra low carbon 18/12/2.3 Mo stainless steel Electrode controlled ferrite content 2%.**

**CLASSIFICATION** : AWS/SFA-5.4: E 316L-16 (Nr.)  
IS-5206: E 19.12.2LR 26 (Nr.)

**APPROVAL** :

**CHARACTERISTICS** : An extra low carbon, rutile coated 18/12/2.3 Mo stainless steel electrode with controlled ferrite content 2% max. resistant to corrosion and cracking. The weld metal is creep resistant and of radiographic quality with stable and smooth arc, easy slag detachability and spatter free welding.

**APPLICATION** :

- 1) Suitable for welding AISI 316 and 316L steels where ferrite content in weld deposit is restricted to less than 2% and for corrosion resistance application.
- 2) Suitable for corrosion resistance required welding such as pickling plates, chemical plants.
- 3) Welding and cladding of 316L UREA GRADE steels.

**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	12.00-15.00	2.00-3.00

### ALL WELD MECHANICAL PROPERTIES:

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

### 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"	80-110	2	20
4.00 X 350	5/ 32" X 14"	110-140	2	20
5.00 X 350	3/ 16" X 14"	140-180	2	20

Customer packing on request.