

**Classifications**

EN ISO 3581-A:2012	: E 19 12 3 L R 12	KS D 7014	: E316L-16
EN ISO 3581-B:2012	: ES316L-16	JIS Z 3221	: ES316L-16
AWS A5.4-06	: E316L-16		

**Description**

- Covering is lime titania type for welding of 18%Cr-12%Ni-Mo stainless steel. (AISI 316) or dissimilar steels.
- Especially suitable for flat and horizontal fillet welding.
- Excellent corrosion resistance against sulphurous acid, phosphoric acid and acetic acid.
- Redry the electrode at 250-350°C for 30-60 minutes prior to use.

**Welding positions****Typical chemical composition of all-weld metal (%)**

C	Si	Mn	P	S	Ni	Cr	Mo	Cu	FN
0.03	0.75	0.80	0.028	0.011	11.71	17.95	2.60	0.12	5.7

\* FN : WRC 1992

**Typical mechanical properties of all-weld metal**

	Y.S(0.2%OS) (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-20°C	-196°C	
AWS A5.4		min. 490	min. 30			
EN ISO 3581-A	min. 320	min. 510	min. 25			
Example	390	570	43	75	40(0.47)	AW

\* AW : As-Welded

**Sizes available and recommended currents (AC or DC +)**

Dia.	(mm)	2.0	2.6	3.2	4.0	5.0
Length	(mm)	250	300	350	350	350
Amp.	F	40-50	55-70	80-110	120-150	140-180
(A)	V · OH	35-45	45-60	70-90	90-130	-

**Approvals**

ABS	BV	DNV	GL	KR	LR
E316L-16	UP	316L	4435	RD316L	316Lm

\* Others : CWB, TUV, CE