

SATINCROME 316L-17

45
OCVAC
DC+

- ▲ Ultra-Seal vacuum packs.
- ▲ Rutile Type, Stainless Steel Electrode.
- ▲ Outstanding Operator Appeal!
- ▲ Now with Improved Slag Lift!
- ▲ All Positional (except vertical down) Welding Capabilities.
- ▲ Advanced Moisture Resistant Flux Coating.

Classifications:

AS/NZS 1553.3: (old)	E316L-17.
AS/NZS 4854: (new)	B ES316L-17
AWS/ASME-SFA A5.4:	E316L-17.

Description and Applications:

Satincrome 316L-17 is a low carbon, rutile type stainless steel electrode manufactured by CIGWELD for the all positional (except vertical-down) fillet and butt welding of 19Cr/10Ni type stainless steels. The features of Satincrome 316L-17 include high AC arc stability, sound radiographic quality, smooth arc transfer characteristics, very low spatter levels and excellent bead shape and contour. The advanced moisture resistant (MR) flux coating provides improved resistance to start-of-run porosity. Slag lift of Satincrome 316L-17 is enhanced in all welding positions, it is self peeling and non-spitting. Applications of Satincrome 316L-17 include the single and multi-pass welding of matching Molybdenum bearing stainless steels, 316 and 316L.

Satincrome 316L-17 is also suitable for the general purpose welding of other "300 series" austenitic stainless steels including 301, 302, 303 and 304/304L, 305, 3CR12 types. The 2.5% Molybdenum content gives increased resistance to pitting corrosion and raises the creep strength for higher temperature applications.

Packaging and Operating Data:

AC (minimum 45 O.C.V.), DC+ polarity.

Electrode Size mm	Electrode Length mm	Approx. No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
2.0	300	87	35-55	2.5kg	15kg - 6 x 2.5kg	611661
2.5	300	46	40-70	2.5kg	15kg - 6 x 2.5kg	611662
3.2	350	28	75-110	2.5kg	15kg - 6 x 2.5kg	611663
4.0	350	18	110-150	2.5kg	15kg - 6 x 2.5kg	611664

Blister Pack:

10 x 2.5mm/5 x 3.2mm

322215

COMPARABLE CIGWELD PRODUCTS:

Autocraft 316LSi GMAW wire
AWS A5.9: ER316LSi

Comweld 316L Gas/TIG wire
AWS A5.9: ER316L.

Verti-Cor 316LT & FCAW wires
AWS A5.20: E316LT1-1

APPROVALS:

American Bureau of Shipping AWS A5.4: E316L-17.

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

0.2% Proof Stress	480 MPa
Tensile Strength.	600 MPa
Elongation	40%
CVN Impact Values	30 J av @ -120°C.

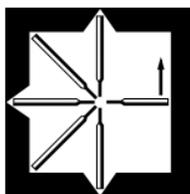
TYPICAL ALL WELD METAL ANALYSIS:

C: 0.025%	Mn: 0.8%	Si: 0.85%
Cr: 19.4%	Ni: 11.5%	Mo: 2.5%
S: 0.011%	P: 0.017%	

FERRITE NUMBER:

3.0 - 10.0 FN*

* - using Severn Gauge



All positional - except vertical down