

Primalloy™ 316L

Stick Electrode - Stainless Steel

Key Features

- ▶ Rutile basic all positional stainless steel electrode
- ▶ Easy slag release, smooth arc
- ▶ Resealable moisture proof packaging

Conformances

AWS A5.4	E316L-16
AS/NZS 4854-B	E316L-16

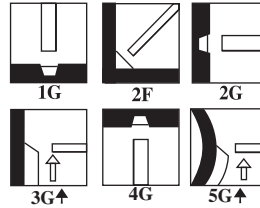
Diameter / Packaging

Diameter mm	Length mm	PE Tube
2.5	300	3162525
3.2	350	3163225
4.0	350	3164025

Typical Applications

- ▶ Suitable for application requiring high resistance to pitting corrosion
- ▶ Designed for joining 316 and 316L stainless steels
- ▶ Applications in exhaust pipe, marine, food beverage, transportation and storage industries

Welding Positions



Mechanical Properties - As Required per AWS A5.4 & AS/NZS 4854-B

	Yield Strength MPa	Tensile Strength MPa	Elongation %
Requirements - AWS	-	490 min	30 min
Requirements - AS/NZS	-	490 min	25 min
Typical Results - As Welded	-	615	45

Deposit Composition

	%C	%Mn	%Si	%P	%S
Typical Results - As Welded	0.03	0.90	0.82	0.020	0.014
	%Ni	%Cr	%Mo	%Cu	
Typical Results - As Welded	11.5	19.7	2.2	0.025	

Typical Operating Procedures

Polarity	Current (amps)		
	2.5 mm	3.2 mm	4.0mm
AC / DC±	45-80	75-110	100-150