



PRODUCT DATA SHEET

STAINLESS STEEL ELECTRODES

Staincord 316L-16



SUMMARY

- > All Positional, Rutile Type Stainless Steel Electrode
- > Extra Low Carbon Weld Deposit
- > For Most Common 300 Series, Stainless Alloys and 409, 444 and 3CR12 Ferric Type Alloys

IDENTIFICATION

Coating - Grey Tip - Plain Imprint - E316/E316L-16

CLASSIFICATION

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

DESCRIPTION AND APPLICATION

Staincord 316L-16 is a "state-of-the-art" formulation for highest quality all position stainless steel welding. The extra low carbon alloy is specifically indicated for general purpose alloy for most common 300 series, stainless alloys and 409, 444 and 3CR12 ferric type alloys. Extra smooth running, high arc stability, easy re-strike, excellent slag removal and bead appearance.

NOTES ON USAGE

1. Clean up the contaminations on the base metal, groove and pass to pass with stainless steel brush.
2. Maintain short arc length. Moving range should be controlled within 2.5 times of the electrodes diameter when you are welding with weave method.
3. Dry the electrodes at 250–300 °C for 60 minutes before using, then store in a hot box at 100–150 °C during welding process.
4. Use lower current to prevent from cracking and minimize base metal dilution.

OPERATIONAL DATA

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	WELDING CURRENT RANGE *(A)
2.6	300	50 - 90
3.2	350	70 - 130

*Recommended for DC + or AC (minimum 45 OCV) operation.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	P	S
0.025	0.85	0.65	18.0	12.0	2.2	0.035	0.013

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Tensile Strength	580 MPa
Elongation	43%

PACKAGING DATA

ELECTRODE SIZE (MM)	PACKAGING (KG)		PART NO.
	PACKET	CARTON	
2.6	2.5	12.5	SC316L26TT
3.2	2.5	12.5	SC316L32TT

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