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| Technical data sheet 190514 | Coated welding electrode <h1>TETRA 316L-E</h1> |  |
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CLASSIFICATION

AWS A5.4 : E316L-16 EN 1600 : E 19 12 3 L R 32
 ISO 3581-A : E 19 12 3 L R 32

DESCRIPTION AND APPLICATIONS

- Rutile basic coated electrode
- Austenitic deposit in CrNi steel - type 316L
- **Joining of low carbon stainless steels and/or stabilised steels with similar compositions, resistant to corrosion**
- Service temperatures from -196°C to +350°C.
- Complements Welding Alloys cored wires TETRA S 316L-G and TETRA V 316L-G

Base materials

Stainless steels for general use:

| UNS | Alloy | EN 10088 | Material N° |
|--------|-------|-------------------|-------------|
| S31600 | 316 | X5CrNiMo17-12-2 | 1.4401 |
| S31603 | 316L | X2CrNi17-12-2 | 1.4404 |
| S31635 | 316Ti | X6CrNiMoTi17-12-2 | 1.4571 |
| S31640 | 316Cb | X6CrNiMoNb17-12-2 | 1.4580 |

TYPICAL ALL-WELD METAL ANALYSIS [%]

| C | Si | Mn | Cr | Ni | Mo |
|-------|-----|-----|------|------|-----|
| <0.03 | 0.8 | 0.7 | 18.5 | 12.2 | 2.8 |

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

| Rm [MPa] | Rp0.2% [MPa] | A % | KCV [J] |
|----------|--------------|-----|------------|
| 580 | 450 | 40 | +20°C : 70 |

OPERATING CONDITIONS

| Electrode ØxL [mm] | 2.5 x 300 | 3.2 x 350 | 4.0 x 350 | 5.0 x 450 |
|--------------------|-----------|-----------|-----------|-----------|
| Current [A] | 75 | 110 | 140 | 180 |

Rebaking if necessary 1h at 250°C. Interpass temperature: < 200°C.

| | |
|-----|-------|
| = + | ~ 70V |
|-----|-------|

WELDING POSITIONS



PACKAGING

| Electrode ØxL [mm] | 2.5 x 300 | 3.2 x 350 | 4.0 x 350 | 5.0 x 450 |
|--------------------|-----------|-----------|-----------|-----------|
| Weight/box [kg] | 5 | 5 | 5 | 6.5 |

Other packaging and other diameters : please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.