Technical data sheet 190514	Coated welding electrode # TETRA 316L-E	Welding Alloys Group

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

1G/PA 2F/PB 2G/PC 3G/PF 4G/PE

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