

OK 316L

Acid-rutile

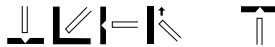
SMAW
E316L-16

Description

OK 316L electrodes have a heavy coating and produce a concave bead with fine ripple. The slag is virtually self-cleaning, and the Molybdenum content increases the resistance to pitting corrosion caused by corrosive media such as sulfuric and sulfurous acids, sulphites, chlorides and cellulose solutions. It is for welding 316 and 316L stainless steel with good bead appearance.

Welding current

DC+, AC OCV 50V



Packing/Ordering Information

| Part Number | Dia mm | Inner Carton | Carton Weight (kg) | Pallet Weight (kg) |
|-------------|--------|--------------|--------------------|--------------------|
| 6398252030 | 2.5 | 1.7 | 10.2 | 785.4 |
| 6398323020 | 3.2 | 4.1 | 12.3 | 811.8 |
| 6398403020 | 4.0 | 4.3 | 12.9 | 851.4 |

Classifications

| | |
|--------------|----------|
| SFA/AWS A5.4 | E316L-16 |
| JIS Z3221 | D316L-16 |

Typical all weld metal composition, %

| C | Si | Mn | Cr | Ni | Mo |
|------|-----|-----|------|------|-----|
| 0.02 | 0.8 | 0.6 | 18.0 | 12.0 | 2.8 |

Typical properties of all weld metal

| | |
|-----------------------|-----|
| Yield stress, Mpa | 435 |
| Tensile strength, MPa | 580 |
| Elongation, % | 40 |

Charpy V

| | |
|----------------|------------------|
| Test temps, °C | Impact values, J |
| +20 | 60 |
| -125 | min. 32 |

Welding parameters

| Diameter, mm | Length, mm | Welding Current, A | Arc Voltage, V | N. | B. | H. | T. |
|--------------|------------|--------------------|----------------|-------------------------------|-------------------------------|-------------------------------|----------------------------------|
| | | | | Kg Weld Metal/(kg) Electrodes | No. of Electrodes/ Weld metal | Kg weld Metal/(hour) Arc Time | Burn-off time, (secs)/ Electrode |
| 2.5 | 300 | 60-90 | 30 | 0.56 | 97.0 | 1.1 | 35 |
| 3.2 | 350 | 80-125 | 31 | 0.61 | 48.0 | 1.4 | 54 |
| 4.0 | 350 | 120-170 | 32 | 0.61 | 32.0 | 2.1 | 55 |
| 5.0 | 350 | 150-240 | 34 | 0.61 | 20.0 | 3.1 | 58 |