



# SS 316

## STAINLESS STEEL ELECTRODE

**CLASSIFICATION :**

IS : 5206-83 : E 19.12.2R26  
AWS/A 5.4 : E 316-16

**APPROVALS :**

EIL, NPC, DESEIN, TOYO

**CHARACTERISTICS :**

A rutile type stainless steel electrode designed for welding of AISI 316 grade stainless steels. The weld metal has high resistance to corrosion, pitting and scaling temperature upto 850°C. Excellent and consistent chemical and mechanical properties, high creep strength at elevated temperature are the salient features. Operates equally well on AC and DC(+) in all conventional positions.

**APPLICATIONS :**

- \* Joining & surfacing of AISI 316 grade.
- \* Clad steels of similar composition.
- \* Highly suitable in chemical industries.

**RECOMMENDATIONS :**

Re-dry the electrodes at 200°C. Use low current short arc and stringer bead technique. Maintain interpass temperature 150°C max.

**CHEMICAL ANALYSIS OF WELD-METAL(%) :**

C	Mn	Si	Cr	Ni	Mo	S	P	Cu
0.08	0.5-2.5	1.0	17-20	11-14	2-3	0.03	0.04	0.75
max		max				max	max	max

**MECHANICAL PROPERTIES OF ALL WELD-METAL (AS PER AWS/A 5.4) :**

Ultimate Tensile Strength	Elongation (GL=4d) (%)	CVN Impact Value at 27°C
N/mm <sup>2</sup>		Joules
520 min	30 min	70 min

**CURRENT CONDITIONS : USE AC OR DC (+)**

Size (mm)	2.5x350	3.15x350	4.0x350	5.0x350
Amps	60-80	80-110	110-140	150-180

**SPECIAL CHARACTERISTICS :**

**DELTA FERRITE :** 5 to 10 FN

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