



SS 316 (0.5 FN)

STAINLESS STEEL ELECTRODE

CLASSIFICATION :

IS : 5206-83 : E 19.12.2 LR 26
AWS/A 5.4 : E 316L-16

APPROVALS :

PDIL

CHARACTERISTICS :

A stainless steel electrode which yields a weld deposit with extra low carbon and has good resistance to intergranular corrosion. Presence of molybdenum provides creep resistance upto 850°C. Suitable for welding in all conventional positions and operates equally well on AC or DC(+).

APPLICATIONS :

- * Welding of Low carbon, Molybdenum bearing, austenitic
- * Stainless Steels Like AISI 316L/ 317L and equivalent grades.
- * Suitable for Fertilizer, Chemical, Textile & Paints industries.

RECOMMENDATIONS :

Re-dry the electrodes at 200°C for one hour. Use lower current. Maintain interpass temperature 150°C max. Use stringer bead technique and short arc. Use stainless steel wire brush for cleaning the welds.

CHEMICAL ANALYSIS OF WELD-METAL(%) :

C	Mn	Si	Cr	Ni	Mo	Cu	S	P
0.04	0.5-2.5	1.0	17-20	11-14	2.0-3.0	0.75	0.03	0.04
max		max			max	max	max	max

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

Ultimate Tensile Strength	Elongation	CVN Impact
N/mm ²	(%)	Values at 27°C
490-600	30-40	Joules 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 : 0.5 FN (max)

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