



SS 316L (NF)

STAINLESS STEEL ELECTRODE

CLASSIFICATION :

IS : 5206-83 : E19.12.2LR26
AWS/A 5.4 : E 316L-16

CHARACTERISTICS :

A stainless steel rutile flux coated with a special controlled composition to give a fully austenitic and non-magnetic weld deposit. The ferrite free weld metal micro structure gives excellent toughness at cryogenic temperatures. The electrode 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 and paints industries.

RECOMMENDATIONS :

Re-dry the electrodes at 200°C for one hour. Use lower current. Maintain an interpass temperature of 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
0.04 max	0.5-2.5	1.0 max	17-20	11-14
Mo	Cu	S	P	
2.0-3.0	0.75 max	0.03 max	0.04 max	

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

Ultimate Tensile Strength	Elongation GL=4d (%)	CVN Impact Values at 27°C
N/mm ²		Joules
490-600	30-40	100 min.

CURRENT CONDITIONS : USE AC(90V) OR DC (+)

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

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