

GRINOX 16L



IDENTIFICATION : GRINOX-16L E316L-16

CLASSIFICATION : AWS/SFA 5.4 : E 316L-16 IS : E 19.12.2 LR 26

CHARACTERISTICS :

A medium heavy coated rutile type stainless steel electrode depositing low carbon 18/13/2.5 Mo austenitic stainless steel weld metal. Deposited weld metal has very high resistance to hot cracking, chemical corrosion upto 800°C and stress corrosion cracking. Molybdenum imparts resistance to corrosion of reducing nature. The deposited weld metal is of radiographic quality.

TYPICAL APPLICATION :

Suitable for welding stainless steels extra low carbon or stabilised by Titanium or Niobium such as AISI grades 316L, 317L and 318, S.S. clad plates, chemical plants, paint and dye industries. For welding stainless steel of 18/8/3 type as represented by AISI grades 316L, 317L & 318.

WELD METAL ANALYSIS (RANGE) % :

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.04 max	0.50-2.50	0.9 max	0.03 max	0.04 max	17.0-20.0	11.0-14.0	2.0-3.0	0.75 max

MECHANICAL PROPERTIES (RANGE) :

Ultimate Tensile Strength MPa	Yield Stress MPa	Elongation (%) (L=4D)	Impact Value
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490 min	400-500	30-40	Temp	Joules
			27°C	70-120

Ferrite content in the weld metal: 3 to 9 FN

REDRYING : 250°C / 2 hrs., max 5 cycles, 10 hr. total.

RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	AMPS AC/DC(+)	PACKING/BOX (PCS)	WEIGHT 1000 PCS (KG)
2.50	350	60-80	100X5=500	20.50
3.15	350	80-110	60x5=300	33.00
4.00	350	110-140	40x5=200	52.00
5.00	350	140-180	25x5=125	82.0