

For Low Carbon 18%Cr - 12%Ni - 2%Mo Stainless Steel

APPLICATIONS

Welding of SUS316L type austenitic stainless steel.

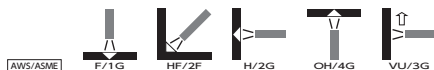
CHARACTERISTICS

S-316L·R is a Low Carbon-18%Cr-12%Ni-2%Mo covered electrode

GUIDELINES FOR USAGE

- 1) Welding is operated in either AC or DC electrode positive polarity.
- 2) Electrodes should be dried at 150~250°C for 60 minutes before use.
- 3) Dirt such as oil, grease and dust should be completely removed from groove.
- 4) Preheat is not necessary, interpass temperature should be less than 150°C
- 5) Excessively wide weaving may cause welding defects. Keep weaving width to less than 2.5 times electrode diameter. Arc length should be kept as short as possible.

WELDING POSITION



■ TYPICAL CHEMICAL COMPOSITION OF WELD METAL (%)

C	Si	Mn	P	S	Ni	Cr	Cu	Mo	Other
0.03	0.46	1.42	0.026	0.011	12.40	19.30	0.02	2.12	—

■ TYPICAL MECHANICAL PROPERTIES OF WELD METAL

Yield Strength, MPa	Tensile Strength, MPa	Elongation, %	Charpy 2V-notch at 0°C, J
436	580	38	98

■ SIZES & RECOMMENDED CURRENT RANGE<AC or DC(+)>

Diameter (mm)		2.0	2.6	3.2	4.0	5.0
Length (mm)		250	300	350	350	350
Current A	F / H-fillet	40~50	55~70	80~100	110~140	140~170
	V-up, OH	35~45	45~65	70~80	100~130	—

Identification color : End-green