S-316LT.16

TYPE : Rutile

AWS A5.4 / ASME SFA5.4 E316L-16
JIS Z3221 ES316L-16
EN 1600 - E 19 12 3 L R

Applications

Welding of extra-low carbon 18%Cr-12%Ni-2%Mo stainless steel for cryogenic applications.

Characteristics on Usage

S-316LT.16 is a lime-titania type electrode for cryogenic applications, low carbon 316L austenitic steel (18%Cr-8%Ni-2%Mo) with good usability and weldability.
It has an excellent resistibility inter-crystalline corrosion in the as-welded condition since carbon content is less, and as it contains Mo., resistance to heat is also good.

Notes on Usage

① Dry the electrodes at 350℃(662℉) for 60 minutes before use.
② Keep the current as low as possible and length as short as possible.
③ Remove rust, water, oil and paint from the groove.

Welding Position

1G (PA) 2F (PB) 3G (PF) 4G (PE)

Current

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.035	0.55	1.59	0.021	0.016	18.5	13.5	2.5

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in²)	EL (%)	Temp. ℃ (℉)	CVN-Impact Value J (ft · lbs)
538 (78,000)	34.4	-196 (-321)	40 (30)

Approval

ABS

Packing

Packet 2.5 ㎏ (5.5 lbs)
Carton 2.5 ㎏ (5.5 lbs) × 4 : 10㎏(22 lbs)

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	2.0 (5/64)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm(in)	300 (12)	300 (12)	350 (14)	350 (14)	350 (14)
F	25 - 55	50 - 85	70 - 115	95 - 150	135 - 180
V-up, OH	20 - 50	45 - 80	65 - 110	85 - 135	-