

SB ZULFI E 316L-15

Brand Name & Classification

AWS/ASME SFA-5.4:E 316L-15
DIN 8556: E 19 12 3 LB 20

Approvals Grade

Properties

Austenitic stainless steel electrode suitable for welding of austenitic Cr-Ni-Mo steels of low carbon content as well as cast steels. Suitable for operating temperatures up to +400⁰ c. Fine droplet metal transfer. Electrodes with lateral expansion upto -196⁰ c can be supplied on special requests

Application

1.4404: X 2 CrNi Mo 17 13 2 1.4571: X 6 CrNi Mo Ti 17 12 22
G-X 2CrNi Mo N 18 10 1.4580: X 6CrNi Mo Nb 17 12 2
1.4406: X 2CrNi Mo N 17 12 2 1.4581: G-X5 CrNi Mo Nb 18
1.4429: X 2 CrNi Mo N 17 13 3 1.4583: X 10 CrNi MO Nb 18 12

Weld Metal Analysis Typical values

Carbon: 0.03

Silicon: 0.80

Manganese: 0.80

Chromium: 18.5

Nickel: 12.0

Molybdenum: 2.70

Typical Mechanical properties

Yield Strength	Tensile Strength	Elongation	Impact Strength
>420 N/MM2	520 - 580 N/mm2	> 35 %	65 J at +20 ⁰ c

Welding Current & Positions



Current

Dia	Length	Amperes
2.5	300	45-80
3.2	350	70-120
4.0	350	100-150