

SR ZULFI E 316L-16

Brand Name & Classification

AWS/ASME SFA-5.4:E 316L-16
DIN 8556: E 19 12 3 LR23

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 +400^o c.

Application

1.4404: X 2 CrNi Mo 17 13 2 1.4571: X 6 CrNi Mo Ti 17 12
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 10
1.4429: X 2 CrNi Mo N 17 13 3 1.4583: X 10 CrNi MO

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 ^o c |

Welding Current & Positions



Current

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