

## Supranox E 316 L

### 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<sup>0</sup> 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 <sup>0</sup> c

### Welding Current & Positions



### Current

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