

### CLASSIFICATION

AWS A 5.4	IS 5206	BS 2926	DIN 8556
E316L - 16	E19.12.2LR26	E19.12.2LR	E19.12.2LR26

### CHARACTERISTICS

A rutile coated stainless steel type 18/13/Mo electrode with an extra low carbon and controlled Ferrite content of 3 to 8% for maximum resistance to corrosion, cracking and scaling temp up to 850 C. It deposits Mo stabilized welds of radiographic welds with excellent creep strength. Weld beads are smooth, uniform and excellent appearance.

### APPLICATIONS

The electrode are suitable for welding of AISI type 316, 316L, 317 Paper pulp industries, Chemical Industries, Fertilizer plants, Paint, Dye industries etc.

### SPECIAL INSTRUCTION

**Available in Vacuum Pack** .Please Re dry the electrode at 250°C for one hour .If the packet is open for 12 hours or more ,5 times max. Do not use excessive currents. Use good fit-up joints. Adopt proper sequence. Remove the slag with a stainless steel wire brush.

### WELDING POSITION



1G



2F



3G



4G

### CHEMICAL COMPOSITION OF ALL WELD METAL

Element	C	Mn	Si	S	P	Cr	Ni	Mo
Percent (max)	0.04	0.50-2.00	1.00	0.020	0.03	17.0 - 20.0	11.0 - 14.0	2.0 - 3.0

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL

UTS (N/mm <sup>2</sup> )	Elongation %
520 - 600	30 min

### CURRENT CONDITION : AC/DC(+)

Size (mm)	Ø 2.50	Ø 3.20	Ø 4.00	Ø 5.00
Current (Amps)	55 - 90	85 - 110	130 - 150	150 - 190

### PACKING DETAILS

	Ø 2.50	Ø 3.20	Ø 4.00	Ø 5.00
DIA (mm)	Ø 2.50	Ø 3.20	Ø 4.00	Ø 5.00
LENGTH (mm)	350	350	350	350
WEIGHT /PKT (Kg)	2	2	2	2
PKT / BOX	5	5	5	5
WEIGHT /BOX (Kg)	10	10	10	10



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