

Stainless Steel SMAW Electrodes

KE316L

AWS A5.4 E316L-16
JIS Z 3221 ES316L-16

Product Features:

- Lime titanium oxide type covered electrode for 316 low carbon content stainless steel, deposited weld metal contains approximately 18%Cr-12%Ni-2%Mo elements.
- Austenite structure weld metal, good heat, corrosion and crack resistance, better intergranular corrosion resistance than 316.
- Weld metal contains Mo element to get good crevice corrosion resistance.

Applications:

- Suitable for welding of severe acid and high heat resistance required SUS316L stainless steel.

Typical chemical composition of all weld metal (wt%)

| C | Si | Mn | Ni | Cr | Mo |
|------|------|------|-------|-------|------|
| 0.02 | 0.71 | 0.63 | 12.38 | 17.91 | 2.37 |

Typical mechanical properties of all weld metal

| Tensile Strength N/mm ² | Elongation % |
|---------------------------------------|-----------------|
| 560 | 41.7 |

Size (mm) & recommended welding parameters (A) AC or DC+

| Diameter / Length | 2.0/300 | 2.6/300 | 3.2/350 | 4.0/350 | 5.0/350 |
|------------------------------|---------|---------|---------|---------|---------|
| Flat position | 40~60 | 60~85 | 85~120 | 115~150 | 150~200 |
| Vertical / overhead position | ---- | 50~75 | 75~105 | 95~130 | ---- |

Note:

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