

ESL'ARC 316



Classification

Class -

IS-5206: E 19.12.2 R26

AWS -

A5.4: E316-16

Applications

Welding of AISI 316,317 grades of stainless steels used in chemical tanks and vats subjected to sulphuric, sulphurous, hydrochloric acids etc. Also used in cladding stainless steel surfaces on impellers, shafts valves etc.

Characteristics

A rutile coated stainless electrode that is suitable for welding 18Cr, 13 Ni, 2.80 Mo type austenitic stainless steel and similar grades. The electrode runs on both AC and DC power sources giving smooth ripple free weld beads and a self-peeling slag. The weld metal has first rate resistance to pitting, corrosion and scaling upto 850°C.

Welding Current: DC+, AC 65

5.00x350mm	4.00x350mm	3.15 x 350mm	2.50x350mm
140-200	100-140	70-110	50-70

Typical Weld Metal Analysis Chemical :

C%	Mn.%	Si%	Cr	Ni	S%	P%	Mo
0.05	0.80	0.70	19.5	12.50	0.02	0.02	2.50

Typical mechanical properties

UTS	YS	Elongation (l=4d)	CVN at RT	Ferrite
600N/mm2	420N/mm2	38%	120 J	3-8



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