

GRINOX 16L

IDENTIFICATION

GRINOX 16L E316L-16

CLASSIFICATION

AWS/SFA 5.4: E 316L-16 IS 5206: E19.12.2 LR16

DESCRIPTION

A medium heavy coated rutile type stainless steel electrode depositing low carbon 18/13/2.5 Mo austenitic stainless steel weld metal. Deposited weld metal has very high resistance to hot cracking, chemical corrosion upto 800°C and stress corrosion cracking. Molybdenum imparts resistance to corrosion of reducing nature. The deposited weld metal is of radiographic quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.04 max	0.50 - 2.50	0.9 max	0.03 max	0.04 max	17.0 - 20.0	11.0 - 14.0	2.0 - 3.0	0.75 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
490 min	30 - 40	27°C	70 - 120

TYPICAL APPLICATIONS

Suitable for welding stainless steels extra low carbon or stabilised by Titanium or Niobium such as AISI grades 316L, 317L and 318, S.S. clad plates, chemical plants, paint and dye industries. For welding stainless steel of 18/8/3 type as represented by AISI grades 316L, 317L & 318.

FERRITE CONTENT IN THE WELD METAL : 3 to 9 FN

REDRYING : 250°C / 2 hrs. Max 5 cycles, 10 hr. total.

WELDING POSITION :



PACKING PARAMETERS

Size (mm)	Length (mm)	AMPS AC / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	60 - 80	2 x 5 = 10	94 x 5 = 470
3.15 / 3.20	350	80 - 110	2 x 5 = 10	60 x 5 = 300
4	350	110 - 140	2 x 5 = 10	38 x 5 = 190
5	350	140 - 180	2 x 5 = 10	24 x 5 = 120