Selectarc 316HR

High efficiency
Stainless Electrode

Classification

AWS A5.4 : E316L-26 EN 1600 : E 19 12 3 L R 7 3
ISO 3581-A : E 19 12 3 L R 7 3

Description & Applications

Synthetic electrode with high recovery (160%) and a Rutile-basic coating giving a 316 L deposit with approx. 8% delta ferrite. Easy striking, soft arc, slag lifts by itself, clean spatter-free welds, finely rippled beads. Used for high efficiency welds, fast deposition, long beads. To weld stainless steels of similar composition in : pulp and paper industry, foodstuff industry...

Base materials

Stainless steels for general use:

UNS	Alloy	EN 10088	Mat. N°	UGINE
S31600	316	X5CRNiMo17-12-2	1.4401	UGINOX 17-10 M
S31603	316L	X2CrNiMo17-12-2	1.4404	UGINOX 18-11 ML
J92900		G-X5CrNiMo19-11-2	1.4408	
S31635	316Ti	X6CrNiMoTi17-12-2	1.4571	UGINOX 17-11 MT
S31635	316Ti	X10CrNiMoTi18-12	1.4573	
S31640	316Cb	X6NiCrMoNb17-12-2	1.4580	
		G-X5CrNiMoNb19-11-2	1.4581	

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Fe
<0.04	0.9	0.7	18.0	11.5	2.5	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
>380	>560	>30	+20℃ >60

Welding Current & Instructions

Electrode	ØxL (mm)	1,6x250	2,0x350	2,5x350	3,2x350	4,0x450
Current	(A)	50	60	90	120	150

Redrying at 300℃ during 1h, if necessary. Interpas s temperature : < 150℃.

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= +	~ 55V