Selectarc 316VD

Stainless Steel Electrode
For vertical down

Classification

AWS A5.4 : E316L–16 EN 1600 : E 19 12 3 L R 3 1
ISO 3581-A : E 19 12 3 L R 3 1

Description & Applications

Low carbon Rutile-basic coated electrode, giving a Mo-containing austenitic stainless steel deposit. This electrode is designed for vertical down welding on Cr-Ni-Mo stainless steels and clad steels which are applied at service temperatures from -120℃ up to + 400℃ in the chemical and petrochemical industries, in refineries…

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-X5CrNiMo 19-11-2	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
<0.03	0.8	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)
>400	>560	>30	+20℃ >60

Welding Current & Instructions

Electrode	ØxL (mm)	2,0x300	2,5x300	3,2x350
Current	(A)	50	70	100

Redrying at 250℃ during 1h. Interpass temperature : < 150℃.

ind.12

= +	~ 80V