

COVERED ELECTRODES FOR STAINLESS STEEL

DESCRIPTION :

SS-316L is a rutile electrode. It possesses properties similar to SS-316 except with a much lower carbon content which reduces susceptibility to sensitization during welding. The welds show high resistance to corrosion and fissuring. This makes it outstanding choice for critical applications. Excellent for welding stainless steel types 316, 316-L and 318.

APPLICATIONS :

Typical applications include stainless steel piping and vessels in oil and gas industry, refineries and chemical and petro-chemical plants.

NOTE ON USAGE :

1. Rebake the electrodes at 250 ~ 300°C for 1 hour and keep it at 100 ~ 150°C prior to use.
2. Use stainless steel wire brush for cleaning of slags
3. Follow the recommended welding parameters to achieve good sound welds

WELDING POSITION:



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

Weld Metal Analysis :

Carbon (C)	0.027
Manganese (Mn)	1.41
Silicon (Si)	0.63
Phosphorus (P)	0.031
Sulphur (S)	0.012
Nickel (Ni)	11.66
Chromium (Cr)	19.43
Molybdenum (Mo)	2.29

TYPICAL MECHANICAL PROPERTIES OF WELD METAL:

TS N/mm ²	551
EL%	39

APPROVALS :

CE,LR

SIZES AND RECOMMENDED CURRENT RANGE (AC or DC <+>)

Diameter mm	Length mm	Amp	
		F	V & OH
2.6	300	50 ~ 85	45 ~ 80
3.2	350	80 ~ 120	70 ~ 110
4.0	350	100 ~ 150	90 ~ 135
5.0	350	140 ~ 180	-