

## SECHERON 316L

**CODIFICATION :** AWS : SFA 5.4 E316L-16

### CHARACTERISTICS AND APPLICATIONS :

- Stainless steel electrode for welding SS316 and its low carbon versions.
- The weld deposit displays good corrosion and crack resistance.
- It meets customer requirements economically.
- It works well with transformer having low OCV also.
- It is ideally suited for joining stainless steels like AISI316 and its low carbon versions, etc. and their equivalent grades in cast variety.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	Cr	Ni	Mo	S	P
Percent	: 0.035	0.80	0.80	18.2	12.1	2.2	0.018	0.020

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	Elongation
(MPa)	(L= 4d)%
530	35.0

### CURRENT AND PACKING DATA: AC / DC(+)

Size (mm)	:	5x350	4x350	3.15x350	2.5x350
Dia x Length					
Current Range	:	150-180	110-140	80-110	60-80
(Amps)					
Weight/Cartron	:	2.0	2.0	2.0	2.0
(kgs)					

### PRECAUTIONS :

- 1 Re-dry the electrodes at 325-375°C for one hour.
- 2 Use short arc, stringer beads and low currents.