Brand Name & Classification
AWS/ASME SFA-5.4: E 316L-16
DIN 8556: E 19 12 3 LR23

Properties
Austenitic stainless steel electrode suitable for welding of austenitic Cr-Ni-Mo steels of low carbon content as well as cast steels. Suitable for operating temperatures up to +400° c.

Weld Metal Analysis
Typical values
- Carbon: 0.03
- Silicon: 0.80
- Manganese: 0.80
- Chromium: 18.5
- Nickel: 12.0
- Molybdenum: 2.70

Application
1.4404: X2 CrNi Mo 17 13 2
1.4571: X6 CrNi Mo Ti 17 12
G-X 2CrNi Mo N 18 10
1.4580: X6 CrNi Mo Nb 17 12 2
1.4406: X2 CrNi Mo N 17 12 2
1.4581: G-X5 CrNi Mo Nb 18 10
1.4429: X2 CrNi Mo N 17 13 3
1.4583: X10 CrNi MO

Typical Mechanical properties
<table>
<thead>
<tr>
<th>Yield Strength</th>
<th>Tensile Strength</th>
<th>Elongation</th>
<th>Impact Strength</th>
</tr>
</thead>
<tbody>
<tr>
<td>&gt;420 N/MM²</td>
<td>520 - 580 N/mm²</td>
<td>&gt; 35 %</td>
<td>65 J at +20° c</td>
</tr>
</tbody>
</table>

Welding Current & Positions
- ~ : +
- ← : ↑
- → : ↓

Current
<table>
<thead>
<tr>
<th>Dia</th>
<th>Length</th>
<th>Amperes</th>
</tr>
</thead>
<tbody>
<tr>
<td>2.5</td>
<td>300</td>
<td>45-80</td>
</tr>
<tr>
<td>3.2</td>
<td>350</td>
<td>70-120</td>
</tr>
<tr>
<td>4.0</td>
<td>350</td>
<td>100-150</td>
</tr>
</tbody>
</table>