Technical data sheet 011121MBA	Coated SMAW Electrode # WA TETRA V 316L-E	Welding Alloys

CLASSIFICATION

ASME IIC SFA 5.4 / AWS A 5.4:	E316L-16
EN ISO 3581-A:	E 19 12 3 L R 1 2
ASME IX Qualification	QW432 F-N° 5 QW442 A-N° 8

DESCRIPTION

- Rutile coated stainless steel SMAW electrode
- 19% Cr - 12% Ni - 2.5% Mo – low carbon type deposit
- Smooth and spatter free arc, automatic slag release
- Excellent weldability in all positions
- Complements Welding Alloys cored wire TETRA V 316L-G

APPLICATIONS

- WA TETRA V 316L-E is suitable for welding stainless steels with an alloy content between 16 to 21% Cr, 6 to 13% Ni and up to 3% Mo, stabilised and unstabilised types.
- For operating temperatures ranging between -196°C and 400°C.

Examples:

AISI	UNS	Material number	EN Symbol
316	S31600	1.4401	X5 CrNiMo 17-12-2
316L	S31603	1.4404	X2 CrNiMo 17-13-2
316LN	S31653	1.4406	X2 CrNiMoN 17-12-2
316Ti	S31635	1.4571	X6 CrNiMoTi 17-12-2
318	S31640	1.4583	X10CrNiMoNb 18-12

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Mn	Si	Cr	Ni	Mo	Fe
0.025	0.7	0.8	18.5	12.0	2.6	Bal.

Typical ferrite level: 8 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	CVN (J)
540	320	25	+20°C: 40

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	CVN (J)
580	450	40	+20°C: 70

OPERATING CONDITIONS

Electrode ØxL [mm]		2.0 x 350	2.5 x 350	3.2 x 350	4.0 x 350
Current [A]		40-75	60-80	80-110	100-150
= +	~ 70 V				

Re-drying: if necessary at 350°C for 1 hour

WELDING POSITIONS

All positions

PACKAGING

Electrode ØxL [mm]	2.0 x 350	2.5 x 300	3.2 x 350	4.0 x 350
Weight/box [kg]	5	5	5	5

Other packaging and other sizes: please consult us