


Technical data sheet <small>011121MBA</small>	Coated SMAW Electrode WA TETRA V 316L-E	
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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

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.