OK 316L



Extra low carbon stainless steel electrode for welding steels of the 18Cr12Ni2.8Mo-type. Also suitable for welding stabilized steels of similar composition except when full creep resistance of the base material is to be matched.

Specifications	
Classifications	SFA/AWS A5.4 : E316L-16 JIS Z 3221 : D316L-16

Welding Current	AC, DC+
Ferrite Content	FN 3-10
Alloy Type	CrNi
Min AC OCV	50

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
AWS			
As Welded	485 MPa	590 MPa	42 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
AWS		
As Welded	20 °C	60 J
As Welded	-60 °C	42 J

Typical Weld Metal Analysis %							
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**	**N**	**FN WRC-92**
0.02	0.6	0.8	11.0	18.1	2.7	0.10	6

Deposition Data					
Diameter	**Current**	**Voltage**	**Efficiency (%)**	**Fusion time per electrode at 90% I max**	**Deposition Rate**
2.5 x 300 mm	45-90 A	29 V	55 %	45 sec	0.9 kg/h
3.2 x 350 mm	60-125 A	30 V	55 %	57 sec	1.4 kg/h
4.0 x 350 mm	70-190 A	32 V	56 %	57 sec	2.0 kg/h