



WELDEX™

316L

STAINLESS STEEL

WX316L-16



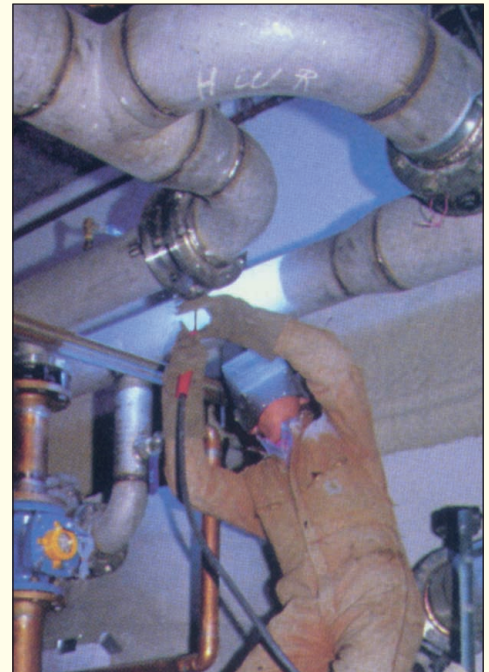
AN AUSTENITIC ELECTRODE DEVELOPED TO WELD A LARGE RANGE OF CORROSION-RESISTANT CR.NI.MO STEELS

Technical Information

Weldex 316L is a high-alloy extra-low carbon Austenitic Electrode for welding corrosion-resistant Cr.Ni.MO steels recommended for stainless steels containing 16-20% chromium, 10-14% Nickel and 2-3% Molybdenum such as A.S.I type 316, 316L and 318 steels. The weldment is resistant to grain disintegration at elevated operating temperatures of up to 350 degrees Centigrade for sustained periods.

Unique Features

- High corrosion resistance
- Low amperage/less distortion
- Smooth clean weld deposit
- Can be used in all positions
- Stable spatter free arc



Application Procedures

This Austenitic electrode can be used to join many various types of stainless steels. Amperage and arc length is kept to a minimum while keeping the electrode angle slightly pointed in the direction of Travel, slag should also be allowed to cool before removal.

Technical Properties

		<u>SIZES</u>	<u>RECOMMENDED</u>
		<u>AVAILABLE</u>	<u>AMPERAGES</u>
Tensile Strength	- 550 - 660 mpa	2.0mm	30-50
	- (81,000 - 96,000 psi)	2.6mm	50-75
Elongation of	- (5 x D) 30%	3.2mm	75-110
Reduction of area	- 50%	4.0mm	110-150