

# Stainless Steel SMAW Electrodes

## G316L

AWS A5.4 E316L-16  
JIS Z 3221 ES316L-16

### Product Features:

- Lime titanium oxide type covered electrode for 316 low carbon content stainless steel, deposited weld metal contains approximately 18%Cr-12%Ni-2%Mo elements.
- Austenite structure weld metal, good heat, corrosion and crack resistance, better intergranular corrosion resistance than 316.
- Weld metal contains Mo element to get good crevice corrosion resistance.

### Applications:

- Suitable for welding of severe acid and high heat resistance required SUS316L stainless steel.

Typical chemical composition of all weld metal (wt%)

| C    | Si   | Mn   | Ni    | Cr    | Mo   |
|------|------|------|-------|-------|------|
| 0.02 | 0.64 | 0.73 | 12.42 | 18.37 | 2.73 |

Typical mechanical properties of all weld metal

| Tensile Strength<br>N/mm <sup>2</sup> | Elongation<br>% |
|---------------------------------------|-----------------|
| 577                                   | 41.6            |

Size (mm) & recommended welding parameters (A) AC or DC+

| Diameter / Length            | 2.0/250 | 2.6/300 | 3.2/350 | 4.0/350 | 5.0/350 |
|------------------------------|---------|---------|---------|---------|---------|
| Flat position                | 30~50   | 60~85   | 85~120  | 110~150 | 150~200 |
| Vertical / overhead position | 30~50   | 50~70   | 75~105  | 95~130  | ----    |