

SMAW

AceWeld 316L-16

For Stainless Steel

CLASSIFICATIONS: AWS A5.4 : E316L-16
 EN ISO 3581-A : E 19 12 L R 12
 EN ISO 3581-B : ES316L-16
 JIS Z 3221 : ES316L-16

WELDING
 POSITIONS :



- **All Position, Rutile Type Stainless Steel Electrode**
- **Low Moisture Pick-up Type Coating**
- **For the Critical Welding of Matching Type 316 and 316L Steels**

DESCRIPTION AND APPLICATIONS

AceWeld 316L-16 is an extra low carbon Rutile type austenitic stainless steel electrode suitable for all positional (except vertical down) performance and with an improved moisture resistant coating for weld metal of high radiographic integrity.

The smooth arc action of this electrode together with low spatter and excellent spay control/detachability, promotes exceptional weld bead appearance and profile.

Other features include high arc stability and easy restriking on low voltage AC welding machine. Aceweld 316L-16 also recommended for general purpose welding of common 300 series stainless steels, such as 301,302, 304 and 304L.

Excellent for welding of Cr-Ni-Mo steels for chemical plant, petroleum, refineries and pulp & paper, etc.

TYPICAL ALL WELD METAL COMPOSITION (Wt%)

C	Mn	Si	Cr	Ni	Mo	S	P
0.022	0.75	0.90	18.5	12.0	2.50	0.010	0.025

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES

YIELD STRESS	TENSILE STRENGTH	ELONGATION	CVN IMPACT VALUES
	590 N/mm ²	40%	80J @ 20°C

OPERATIONAL AND PACKAGING DATA

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE(amps.)	PACKAGING (KG)	
			PKT	CTN
2.0	300	35 - 45	2.5	20
2.6	300	50 - 80	2.5	20
3.2	350	70 - 100	2.5	20
4.0	350	100 - 150	2.5	20
5.0	350	140 - 190	2.5	20

- Recommended for DC+ or AC (minimum 55 OCV) operation.
- Available in 1 KG packaging.
- Also available in Solid Mig Wire: MIG MC-316LSi, Tig Rod: TIG MC-316L/LSi, Flux Cored Wire: COREMAX 316LP