

SMAW

AceWeld 316L-17

For Stainless Steel

CLASSIFICATIONS: AWS A5.4 : E316L-17
 EN ISO 3581-A : E 19 12 3 L R 12
 EN ISO 3581-B : ES316L-17
 JIS Z 3221 : ES316L-17

WELDING
 POSITIONS :



- **All Position, Rutile Silica Type Stainless Steel Electrode**
- **Low Moisture Pick-up Type Coating**
- **Allow Much Higher Welding Currents Than L-16 Electrode**

DESCRIPTION AND APPLICATIONS

AceWeld 316L-17 is an extra low carbon Rutile silica type stainless steel electrode for all position welding (except vertical down) of 316 and 316L plate or pipe-work. This electrode provides good resistance to corrosion intended for applications where service temperature do not exceed 400°C.

This electrode feature excellent weldability, soft fusion, excellent slag removed, low spatter, easy striking and restriking, low moisture absorption coating and recommended for general purpose welding of common 300 series stainless steels, such as 301, 302, 304 and 304L

TYPICAL ALL WELD METAL COMPOSITION (Wt%)

C	Mn	Si	Cr	Ni	Mo	S	P
0.023	0.70	0.90	18.8	12.0	2.50	0.012	0.020

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES

YIELD STRESS	TENSILE STRENGTH	ELONGATION	CVN IMPACT VALUES
	610 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	40 - 50	2.5	20
2.6	300	55 - 85	2.5	20
3.2	350	80 - 120	2.5	20
4.0	350	110 - 150	2.5	20

- Recommended for DC+ or AC (minimum 55 OCV) operation.
- Available in 1 KG packaging.
- Re-dry electrode at 300°C - 350°C for 1 hour if necessary
- Also available in: Solid Mig Wire : MIG MC-316LSi, Tig Rod : TIG MC-316L/LSI, Flux Cored Wire : COREMAX 316LP