

Manual Metal Arc Electrodes

Stainless Steel MMA Electrodes

Nicrex E316L



AWS A/SFA 5.4-92 E316L-17
EN 1600 E 19 12 3 LR 12

Description and applications

This is an extra low carbon, acid-rutile coated electrode for welding molybdenum bearing stainless steels of the 316 and 316L type. Nicrex E316L combines very high quality weld metal with good welder appeal. Features include first time striking and re-striking, and a smooth arc with very little spatter.

All-weld metal properties

	Composition wt %		AWS Mechanical	As-welded	
	Min	Max			
C		0.03	0.2% PS	320 min	N/mm ²
Si		0.90	UTS	510	N/mm ²
Mn	0.50	1.20	Elongation	33 min	%
S		0.02			
P		0.025	Charpy V impact values	at +20°C	47 min ave J
Cr	17.0	19.0	Ferrite level	FN 3-10	
Ni	11.0	13.0			
Mo	2.5	3.0			
Cu		0.20			

Current range

	AC (min OCV 50) or DC +					
Size (mm)	1.6	2.0	2.5	3.2	4.0	5.0
Current (amps)	30-45	45-65	45-90	60-125	70-190	100-280