

Stainless Steel Electrodes

Alloy: WW316L-16 Class: E316L-16

Conforms to Certification: AWS A5.4 ASME SFA A5.4

Alloy: E316L-16

Weld Process: Shielded Manual Metal Arc

AWS Chemical Composition Requirements

C = 0.04 max	Si = 1.0 max
Cr = 17.0 – 20.0	P = 0.04 max
Ni = 11.0 – 14.0	S = 0.03 max
Mo = 2.0 – 3.0	Cu = 0.75 max
Mn = 0.5 – 2.5	

Deposited All Weld Metal Properties %
(Typical) As-Welded

Yield Strength	85,800psi
Tensile Strength	58,000psi
Elongation	36%

Deposited Chemical Composition % (Typical)

C = 0.03	Si = 0.52
Cr = 18.70	P = 0.024
Ni = 12.65	S = 0.022
Mn = 1.75	Mo = 2.30

Deposited Charpy-V-Notch Impact Properties %

Not Applicable

Recommended Welding Parameters

<u>Diameter</u>	<u>Voltage</u>	<u>Amperage Flat Position</u>	<u>Amperage Vertical & Overhead</u>
3/32	24-28	70-85	65-75
1/8	26-30	85-110	80-90
5/32	28-32	110-140	100-120
3/16	28-32	120-160	110-130

Application

E316L-16 electrodes deposit type 316 with a maximum of 0.04% carbon in the weld deposit. This electrode is used for welding type 316L or type 316 steels. Widely used in the welding of chemical holding equipment.

