

SATINCROME 316L-17

45
OCV

AC
DC+

- Rutile Type, Stainless Steel Electrode.
- Outstanding Operator Appeal!
- Now with Improved Slag Lift!
- Positional (except vertical down) Welding Capabilities.
- Advanced Moisture Resistant Flux Coating.
- Packed in Resealable Plastic Tubes

Classifications:

ISO AS/NZS 4854: B ES316L-17
AWS/ASME-SFA A5.4: E316L-17

Description and Applications:

Satinchrome 316L-17 is a low carbon, rutile type stainless steel electrode manufactured by CIGWELD for the all positional (except vertical-down) fillet and butt welding of 19Cr/10Ni type stainless steels. The features of Satinchrome 316L-17 include high AC arc stability, sound radiographic quality, smooth arc transfer characteristics, very low spatter levels and excellent bead shape and contour. The advanced moisture resistant (MR) flux coating provides improved resistance to start-of-run porosity. Slag lift of Satinchrome 316L-17 is enhanced in all welding positions, it is self peeling and non-spitting. Applications of Satinchrome 316L-17 include the single and multi-pass welding of matching Molybdenum bearing stainless steels, 316 and 316L.

Satinchrome 316L-17 is also suitable for the general purpose welding of other "300 series" austenitic stainless steels including 301, 302, 303 and 304/304L, 305, 3CR12 types. The 2.5% Molybdenum content gives increased resistance to pitting corrosion and raises the creep strength for higher temperature applications.

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.025% Mn: 0.8% Si: 0.85%
Cr: 19.4% Ni: 11.5% Mo: 2.5%
S: 0.011% P: 0.017%

FERRITE NUMBER:

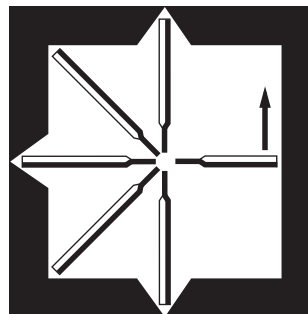
3.0 - 10.0 FN*
* - USING SEVERN GAUGE

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

0.2% Proof Stress 480 MPa
Tensile Strength. 600 MPa
Elongation 40%
CVN Impact Values 30 J av @ -120°C.

COMPARABLE CIGWELD PRODUCTS:

Autocraft 316LSi GMAW wire
AWS A5.9: ER316LSi
Comweld 316L Gas/TIG wire
AWS A5.9: ER316L.
Verti-Cor 316LT & FCAW wires
AWS A5.20: E316LT1-1



All positional -
except vertical down

Packaging and Operating Data:

AC (minimum 45 O.C.V.), DC+ polarity.

Electrode Size mm	Electrode Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
2.0	300	84	45-65	1.6kg	9.6kg - 6 x 1.6kg	611661N
2.5	300	52	40-90	1.7kg	10.2kg - 6 x 1.7kg	611662N
3.2	350	27	60-125	2.0kg	12kg - 6 x 2.0kg	611663N
4.0	350	18	70-190	4.3kg	12.9kg - 3 x 4.3kg	611664N