

SATINCROME 316L-17

PRODUCT DATA SHEET



**LOW CARBON,
RUTILE TYPE STAINLESS
STEEL ELECTRODE**

**45
OCV**

**AC
DC+**

STAINLESS STEEL AND SPECIAL ELECTRODES

SATINCROME 316L-17

- 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

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

TYPICAL ALL WELD METAL ANALYSIS:

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

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.

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

PACKAGING & OPERATING DATA:

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

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	APPROX NO. RODS/KG	CURRENT RANGE (AMPS)	PACK SIZE	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	2kg	12g - 6 x 2kg	611663N
4.0	350	18	70-190	4.3kg	12.9kg - 3 x 4.3kg	611664N

FERRITE NUMBER:

3.0 - 10.0 FN*

* - USING SEVERN GAUGE

WELDING POSITIONS:

All positional - except vertical down.

