

CIGWELD

AN ESAB BRAND

WELDSKILL 316L

PRODUCT DATA SHEET



**WELDSKILL ELECTRODE
HANDY-PACKS FOR ALL OF
YOUR SMALLER PROJECTS**



**AC
DC+**

**45
OCV**

STAINLESS STEEL

WELDSKILL 316L:

WELDSKILL 316L stainless steel electrode for the all positional (except vertical-down) fillet and butt welding of stainless steels.

WELDSKILL 316L is suitable for a wide range of welding applications including the single and multi-pass welding of matching Molybdenum bearing stainless steels, 316 and 316L.

Also suitable for the general purpose welding of other "300 series" austenitic stainless steels including 301, 302, 303 and 304/304L, 305, 3CR12 types.

Also suitable for the general welding of 400 series stainless steels including 410 and 430.

FEATURES:

- E316L-16 type stainless steel electrode
- Produces low spatter levels as well as smooth running
- Designed for fillet & butt welding in all positions except vertical-down
- For the welding of matching 316 and 316L stainless steel grades

CLASSIFICATIONS:

AS/NZS 4854: **ES316L-16**

AWS A5.4: **E316L-16**

SPECIFICATIONS:

Diameter (mm)	Current Range (amps)	
	MIN	MAX
2.0	30	60
2.5	40	70
3.2	75	110

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

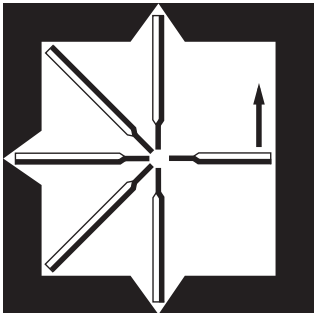
Yield Strength	490 MPa
Tensile Strength	620 MPa
Elongation	40%
CVN Impact Values	35J av @ -196°C

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.03%	Mn: 0.8%	Cr: 19.5%
Ni: 11.5%	Si: 0.85%	Mo: 2.5%

WELDING POSITIONS:

All positional - except vertical down welding



ORDERING INFO:

PART NO.	SIZE PACK	SIZE	CARTON
WES316120	WeldSkill 316L Stainless Steel Electrodes 2.0mm	1kg	12kg - 12 x 1kg
WES316125	WeldSkill 316L Stainless Steel Electrodes 2.5mm	1kg	12kg - 12 x 1kg
WES316132	WeldSkill 316L Stainless Steel Electrodes 3.2mm	1kg	12kg - 12 x 1kg