Arcaloy MC316L

Arcaloy MC316L is a composite metal cored stainless steel wire which has a stainless steel sheath. The addition of molybdenum helps reduce pitting corrosion. As a small diameter cored wire it can be used for the welding of thin gauge 316, 316L and sometimes 304 and 304L stainless steels. Its higher deposition rate and less penetration compared to solid wire makes it very suitable for making butt, fillet and lap welds on gauge material. Higher speeds are also possible compared to solid wire. The low spatter and slag-free welds make this electrode ideal for automatic and robotic welding. The pushing technique can be used to further minimize the penetration and oxide film formed on the surface of the weld. Typical applications include automobile catalytic converters, manifolds, mufflers, exhaust systems. For welding in the spray mode of metal transfer, the shielding gas should be argon with 1 or 2% oxygen or carbon dioxide. Pulse welding can also be used to further minimize penetration in thin gauge steels. This metal cored wire can also be used in submerged arc welding. It can be used with ESAB OK 10.93 flux.

Specifications	
Classifications	SFA/AWS A5.22 : EC316L
Industry	Mobile Equipment Automotive Pipeline Ship/Barge Building Industrial and General Fabrication

Welding Current	DC+
Alloy Type	MC316L

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	Cu	Ferrite FN
0.02	1.40	0.50	12	18.50	2.70	0.10	7

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	144-441 A	16-30 V	4.06-14.73 m/min	1.9-7.2 kg/h