

Nicrex E316L

Stainless steel electrode with extra low carbon content for welding steels of the 18Cr 12Ni 2.8Mo-type. Also suitable for welding stabilized steels of similar composition except when full creep resistance of the base material is to be matched.

Specifications

Classifications	EN ISO 3581-A : E 19 12 3 L R 1 2 SFA/AWS A5.4 : E316L-17
Approvals	CE : EN 13479

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+, AC
Ferrite Content	FN 3-10
Alloy Type	Austenitic CrNiMo
Coating Type	Acid Rutile

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	460 MPa	570 MPa	40 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	20 °C	60 J
As Welded	-20 °C	55 J
As Welded	-60 °C	43 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	N	Ferrite FN
0.02	0.6	0.8	11.0	18.1	2.6	0.10	6

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.0 x 300.0 mm	45-65 A	29 V	60 %	39 sec	0.6 kg/h
3.2 x 350.0 mm	60-125 A	30 V	55 %	57 sec	1.4 kg/h