

Cryoarc 316L-15

Cryoarc 316L-15 is a stainless steel electrode used for welding steels of the CrNiMo 17-12-3 type. It has been designed especially for cryogenic and LNG applications where impact toughness properties down to low temperatures are asked for. It meets lateral expansion requirements of min. 0.38mm at -196°C. The basic coating provides good hot cracking resistance and excellent vertical welding characteristics. It can also be used where low magnetic permeability is required.

Specifications

Classifications	SFA/AWS A5.4 : 316L-15
Welding Current	AC, DC+
Ferrite Content	max. FN 2
Alloy Type	Austenitic CrNiMo
Coating Type	Basic

Typical Tensile Properties

Condition	Tensile Strength	Elongation
As Welded	552 MPa (80 ksi)	45 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	-196 °C (-320 °F)	47 J (35 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	N	Ferrite FN
0.03	2.0	0.5	13.6	18.0	2.2	0.05	5