


316L-HS High Security
STAINLESS STEEL

DESCRIPTION

All position stainless steel 316L type electrode with a unique **high security coating** engineered to **eliminate the slag from "popping" when the weld cools**. Recommended for welding of Cr-Ni-Mo stainless steel grades (316L, 317L, 318).

CHARACTERISTICS

- High security coating (no popping slag)
- Conforms to specifications AWS A5.4 E316L
- Excellent all position weldability
- Excellent on AC / DC+ power supply
- High chemical product resistance
- Stable arc with low spatter
- Low carbon filler metal

TYPICAL APPLICATIONS

Welding of Cr-Ni-Mo steels for chemical plants, petroleum plants, refineries, pulp and paper, etc. Tanks, pipes, heat exchangers, etc.

PROCEDURE

Clean welding area. Keep a short arc with the electrode slightly inclined or always in contact with the part. Remove flux between each pass. Use only dry electrodes.

MECHANICAL PROPERTIES

Tensile strength: > 81 455 psi (560 MPa)
 Yield strength: > 58 200 psi (400 MPa)
 Elongation: > 30 %

WELDING PARAMETERS

Diameter:	3.2 mm (1/8")	2.5 mm (3/32")
Amperage:	90 - 110 A	60 - 80 A

N.B. Diameter 3.2 mm (1/8") is available on request

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Specialized welding alloys and technology. For technical assistance or for ordering: