


316L-VD Vertical down
STAINLESS STEEL

DESCRIPTION

All position stainless steel 316L type electrode **certified by the Canadian Welding Bureau (CWB)** and with a unique coating designed for **vertical down welding** of Cr-Ni-Mo stainless steel grades (316L, 317L, 318).

CHARACTERISTICS

- **Certified by CWB to CSA W48-18**
- Conforms to specifications AWS A5.4 and ASME SFA 5.4
- All position including vertical down
- Excellent on AC / DC+ power supply
- High chemical product resistance
- Temperature resistance: -120°C to 350°C (-184°F to 662°F)
- Moisture resistance rutile-basic coating
- Available in diameter 2,0 mm (5/64")

TYPICAL APPLICATIONS

Excellent for welding thin sheet and stainless steel pipe. Welding of Cr-Ni-Mo steels for chemical plant, petroleum, refineries and 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")	2.0 mm (5/64")
Amperage:	90 - 110 A	60 - 80 A	40 - 60 A

Rev.: 21_08

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