

MMA Electrodes Stainless and Heat resistant steels

Supranox 316LP has a thin basic-rutile coating for welding austenitic stainless Cr-Ni-Mo steels/ cast steels, having an extra low carbon content. For operating temperatures of up to +400 °C. Supranox 316LP is a good compromise between ease of use when positional welding and bead finish. Especially recommended for welding tubes.

Classification	
AWS	A5.4: E316L-16
EN	1600: E 19 12 3 L R 12

Approvals	Grades

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
≤ 0.03	1.30	0.60	≤ 0.025	≤ 0.020	19.20	12	2.80	-	-	-	5-10

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) + 20 °C	Hardness
As Welded	≥ 400	≥ 520	≥ 30	≥ 60	-

Materials

1.4401 (X4CrNiMo17-12-2), 1.4435 (X2CrNiMo18-14-3)
1.4571 (X6CrNiMoTi17-12-2), 1.4583 (X10CrNiMoNb18-12)
AISI 316L

Storage and redrying

Keep dry and avoid condensation.
Re-drying not generally required
If necessary: 300-350 °C for 2 hours, 5 times max

Current condition and welding position

DC+; AC



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,0	300	35-60	10,1	6,0
2,5	300	45-80	16,3	9,8
3,2	350	70-120	33,0	19,8
4,0	350	100-150	53,4	32,0