SUPRANOX 316L-PG

OERLIKON

MMA Electrodes
Stainless and Heat resistant steels

Rutile coated MMA electrode for the vertical-down welding of austenitic stainless Cr-Ni-Mo steels and cast steels, having a low carbon content. For operating temperatures of up to +400 °C. Fine metal droplet transfer, good fusion of joint faces, finely rippled bead surface, easy slag removal, easy arc striking and restriking. Can be used for joining stainless and C-Mn steels.

Classification	
AWS	A5.4: E316L-16
EN	1600: E 19 12 3 L R 15

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
≤ 0.03	0.70	0.80	≤ 0.025	≤ 0.020	18.50	11.50	2.50	-	-	-	5-10

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm²	Tensile Strength N/mm²	Elongation A5 (%)	Impact Energy ISO - V (J) + 20 °C	Hardness
As Welded	≥ 400	≥ 520	≥ 30	≥ 50	-

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

PG

Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	300	45-70	15,1	10,1
3,2	350	70-110	28,5	20,0