

SUPRANOX RS 316L

MMA Electrodes Stainless and Heat resistant steels

Semi-basic MMA electrode suitable for the welding of austenitic stainless steels containing 16-20% Cr, 10-14% Ni and 2-3% Mo (AISI 316 and 316L). Good chemical corrosion resistance. The low carbon content of the weld deposit ensures a high resistance to weld cracking. Max. service temperature +400°C. Excellent weldability with a spatter free arc; self-releasing slag combined with a very smooth bead appearance. Efficiency 100%. Packed in Gaspack system.

Classification	
AWS	A5.4: E 316L-16
EN	1600: E 19 12 3L R12
GOST	10052-75: Э02Х20N14Г2 М 2Б

Approvals	Grades
ABS	
MMI	
RINA	
TÜV	

see Appendix, Classification Society Approvals, for details pag. 521

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.03	0.75	0.70	≤ 0.025	≤ 0.020	19	12	2.20	-	-	-	4-8

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	≥ 350	≥ 510	≥ 30	≥ 47	-

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: 350-370 °C for 1 hour, 3 times max

Current condition and welding position

AC; DC+



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
1,5	250	20-30	5,4	3,2
2,0	300	30-60	11,5	6,9
2,5	300	50-80	18,4	11,3
3,2	350	60-120	35,7	21,4
4,0	350	100-140	52,3	31,3
5,0	350	130-190	84,8	50,8