BASINOX 316L

OERLIKON

MMA Electrodes
Stainless and Heat resistant steels

Basic coated MMA electrode for welding austenitic stainless Cr-Ni-Mo steels and cast steels, having a low carbon content. For operating temperatures of up to +400 °C. Very good positional welding characteristics. Easy slag release. Vacuum packaging.

Classification	
AWS	A5.4: E316L-15
EN	1600: E 19 12 3 L B 42

Approvals	Grades
DB	
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
≤ 0.04	1	0.40	≤ 0.025	≤ 0.020	18.50	11.50	2.70	-	-	-	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	≥ 420	≥ 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: 280-300 °C for 1 hour, 5 times max

Current condition and welding position

DC+

Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	300	45-85	16,8	0,0
3,2	350	50-125	33,3	0,0
4,0	350	90-150	47,5	0,0
5,0	350	140-185	0,0	0,0