BASINOX 316L VU

OERLIKON

MMA Electrodes
Stainless and Heat resistant steels

Low hydrogen MMA electrode suitable for the welding of stainless steels type AISI 316 and 316L. Excellent performance in the vertical-up position. The low carbon content results in improved corrosion resistance. Efficiency 100%.

Classification	
AWS	A5.4: E 316L-15
EN	1600: E 19 12 3L B 12
GOST	10052-75: Э02Х20Н14Г2 М 2Б

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.025	1.30	0.30	≤ 0.030	≤ 0.030	18.50	12.50	2.50	-	-	-	3-8

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	≥ 550	≥ 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: 280-300 °C for 1 hour, 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)
2,5	300	45-70	18,6	11,1
3,2	350	65-120	33,3	19,9
4,0	350	115-140	52,0	31,2