OK 316L

SMAW

OK 316L electrodes have a heavy coating and produce a concave bead with fine ripple. The slag is virtually self-cleaning, and the Molybdenum content increases the resistance to pitting corrosion caused by corrosive media such as sulfuric and sulfurous acids, sulphites, chlorides and cellulose solutions. It is for welding 316 and 316L stainless steel with good bead appearance.

Welding Current
DC+, AC OCV 50V

PACKING/ORDERING INFORMATION				
Part Number	Dia (mm)	Inner Carton (kg)	Carton Weight (kg)	Pallet Weight (kg)
6398252030	2.5	1.7	10.2	785.4
6398323020	3.2	4.1	12.3	811.8
6398403020	4.0	4.3	12.9	851.4

CLASSIFICATIONS	TYPICAL ALL WELD METAL COMPOSITION (%)		TYPICAL MECH. PROPERTIES ALL WELD METAL
SFA/AWS A5.4	C	0.02	Yield Stress, Mpa
E316L-16	Si	0.8	435
JIS Z3221	Mn	0.6	Tensile Strength, Mpa
D316L-16	Cr	18.0	580
	Ni	12.0	Elongation, %
	Mo	2.8	40
			Charpy V
			Test Temps, °C — Impact Values, J
			+20 — 60
			-125 — min. 32

WELDING PARAMETERS							
Diamater (mm)	Length (mm)	Welding Current, A	Arc Voltage, V	N. Kg Weld Metal/(kg) Electrodes	B. No. Of Elec-trodes/(kg) Weld Metal	H. Kg Weld Metal/(hour) Arc Time	T. Burn-off time, (secs)/ Electrode
2.5	300	60-90	30	0.56	97.0	1.1	35
3.2	350	80-125	31	0.61	48.0	1.4	54
4.0	350	120-170	32	0.61	32.0	2.1	55
5.0	350	150-240	34	0.61	20.0	3.1	58