PRODUCT DATA SHEET

WCD 6116

STAINLESS STEEL ARC WELDING ELECTRODES

STAINCORD 316L-16

- All Positional, Rutile Type Stainless Steel Electrode
- Moisture Resistant, "Colour Coded" Flux Coating
- Extra Low Carbon Weld Deposit
- For the Critical Welding of Matching Type 316 and 316L Steels

Identification

Coating - Dust Pink

End Tip - Green

Imprint - 316L-16

Classifications

AS/NZS 1553.3	E316L-16 (Superseded)
AWS A5.4	E316L-16
AS/NZS	4854 ISO 3581B ES316L-16*

*New classification replaces AS/NZS 1553.3

Description & Applications

New generation STAINCORD 316L-16 is an extra low carbon, rutile type electrode exhibiting superior all positional (except vertical down) performance with an improved moisture resistant "Pink" flux coating for weld metal of high radiographic integrity. The smooth arc action of Staincord 316L-16, together with low spatter and excellent slag control/detachability, promotes exceptional weld appearance and profile. Other features include high arc stability and easy restriking on low voltage AC welding machines.

Staincord 316L-16 deposits Molybdenum bearing, 19Cr/12Ni/2.5Mo filler metal to meet the requirements for welding type 316 and 316L stainless steels in critical applications. Staincord 316L-16 is also recommended for the general purpose welding of common 300 series stainless steels, such as 301, 302, 304 and 304L. It is also suitable for the general welding of ferritic stainless steel alloys, such as 409, 444 and 3Cr12.

Operational Data

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE * (amps)	ARC VOLTAGE RANGE (volts)**
2.0	300	30 - 50	20
2.5	300	50 - 75	21
3.2	350	75 - 110	26

*Recommended for DC+ or AC (minimum 45 0CV) operation

* * Voltage is determined by arc current and electrode arc length. Arc voltage shown are typical and are only to be used as a guide.

Typical All Weld Metal Chemical Analysis

C	Mn	Si	Cr	Ni	Mo	Fe
0.025	0.7	0.7	18.5	12.0	2.4	Bal

Typical All Weld Metal Mechanical Properties

Yield Stress	380 Mpa
Tensile Strength	600 Mpa
Elongation	40%

In as welded condition.

Packaging Data

ELECTRODE SIZE (mm)	PACKAGING (KG)			APPROX NO OF RODS PER KG	PART NUMBER
	Packet	Carton	Mini Pack		
2.0	2.5	15	0.5	86	SC31620 SC31620M
2.5	2.5	15	0.5	55	SC31625 SC31625M
3.2	2.5	15	0.5	27	SC31632 SC31632M

Storage Information

Products should be stored in dry conditions in original sealed undamaged packaging as supplied. The intergrity of consumable products can be adversely affected by time and storage conditions and that the detail shown in the batch certificate is true at the time of packaging and is only valid for a LIMITED time. After that time the product may need to be reconditioned or checked to ensure it is suitable for the purpose it is intended to be used for.* To recondition moist electrodes bake for two hours at 200^{0}C. Do not exceed 250^{0}C.

*NOTE: Refer to Welding Technology Institute of Australia (WTIA), technical 3. care and conditioning of arc welding consumables.

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