

Inweld 316L-16

AWS A5.4 E316L-16

Chemical Composition of Inweld 316L-16

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu
Balance	0.04	17.0	11.0	2.0-3.0	0.5-2.5	0.90	0.04	0.03	---	0.75
		-20.0	-14.0							

Single values are maximum unless otherwise specified.

Description and Applications

Grey flux coating designed with low carbon levels to help eliminate carbide precipitation on high temperature service. Suitable for titanium and niobium stabilized versions of 316L stainless steel. Extra low carbon content to resist pitting in all welding positions.

316L-16 is a maintenance quality, smooth running molybdenum bearing electrode for molybdenum bearing stainless steels with 1.5 to 3.0% Mo. Primarily used for resistance to pitting, many acids and general corrosion. Flux coating provides smooth arc transfer in all welding positions except vertical down.

Typical Weld Metal Properties

	<u>AWS Spec</u>
Tensile Strength:	70,000 psi
Yield Strength:	55,000 psi
Elongation:	30%

Recommended Parameters

SMAW (AC & DCEP)

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>
3/32"		65-75
1/8"		90-105
5/32"		120-135
3/16"		135-155

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