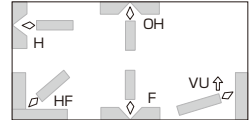


Covered electrode for low carbon 18%Cr-12%Ni-2%Mo steel**Classification:** ASME / AWS A5.4 E316L-16**Features:** - Applicable for 316L type steel
- Lower carbon content than **NC-36****Redrying Conditions:** 150~200°Cx0.5~1h**Identification color:** 1st Green, 2nd -**Welding Positions:****Chemical composition of all-weld metal (%) as per AWS**

	C	Si	Mn	P	S	Ni	Cr	Mo
Example	0.023	0.57	1.56	0.025	0.003	12.17	18.68	2.20
Guaranty	≤0.04	≤0.90	0.5~ 2.5	≤0.04	≤0.03	11.0~ 14.0	17.0~ 20.0	2.0~ 3.0

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)
Example	420	580	45	0°C: 83
Guaranty	-	≥485	≥30	-

Recommended welding parameters

	2.0mm	2.6mm	3.2mm	4.0mm	5.0mm
F, HF, H	25~55A	50~85A	70~115A	95~145A	135~180A
VU, OH	20~50A	45~80A	65~110A	85~135A	-

Polarity

Example	AC
Guaranty	AC, DC-EP

Approvals

ABS	LR	DNV	BV	NK	GL
MG(E316-16)	316Lm(Chem.)	316L	UP(E316L-16)	KD316L	4435

Packages

Dia. (mm)	Length (mm)	Weight per pack (kg)	Weight per carton (kg)	Weight per piece (g)
2.0	250	2	20	10
2.6	300	2	20	19
3.2	350	5	20	34
4.0	350	5	20	51
5.0	350	5	20	78