

OK 316L



Extra low carbon stainless steel electrode for welding steels of the 18Cr12Ni2.8Mo-type. Also suitable for welding stabilized steels of similar composition except when full creep resistance of the base material is to be matched.

Classifications	SFA/AWS A5.4 : E316L-16 JIS Z 3221 : D316L-16
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Welding Current	AC, DC+
Ferrite Content	FN 3-10
Alloy Type	CrNi
Coating Type	Acid-Rutile

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	485 MPa	590 MPa	42 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As Welded	20 °C	60 J
As Welded	-60 °C	42 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	N	Ferrite FN
0.02	0.6	0.8	11.0	18.1	2.6	0.10	6

Deposition Data

Diameter	Current	Voltage	Number of electrodes/ kg weld metal	Fusion time per electrode at 90% I max	Deposition Efficiency %	Deposition Rate @ 90% I max
2.5 x 300.0 mm	45-90 A	29 V	96	45 sec	55 %	0.9 kg/h
3.2 x 350.0 mm	60-125 A	30 V	52	57 sec	55 %	1.4 kg/h
4.0 x 350.0 mm	70-190 A	32 V	34	57 sec	56 %	2.0 kg/h