



Manufacturers of Custom Welding Lines for Resale  
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# SELECTRODE 1156 316L-16

## INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.4 E 316L-16

EN 1600: E 19 12 3 LR 32

DIN 8556: E 19.12.3 LR 26

ISO 3581: E 19.12.3 LR 32

NFA 81-343: EZ 19.12.3 LR 26

BS 619: E 5122 R 12

## FEATURES & APPLICATIONS

For molybdenum bearing stainless steels with 1.5 to 3.0% Mo. Primarily used for resistance to pitting, many acids and general corrosion.

Maintenance quality smooth running molybdenum bearing 316L-16 electrode

- Excellent all position capabilities.
- Extra low carbon content to resist pitting.
- Suitable for titanium and niobium stabilized versions of 316L stainless.

## ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

**Microstructure:** Austenite with 7-9% ferrite. Typical ferrite number is 6.

**Flux Color:** White-Grey

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Fe
.018	.9	.75	.01	.02	19	12	2.65	.1	bal

## TYPICAL MECHANICAL PROPERTIES

<b>Undiluted Weld Metal</b>	<b>Maximum Value Up to:</b>
Tensile Strength	80,000 PSI (550 MPa)
Yield Strength	56,000 PSI (390 MPa)
Elongation	42%
Impact Energy	40J: -157°F (-105°C)
Hardness	Brinell 209, Rockwell B96

## WELDING CURRENT & INSTRUCTIONS

**Recommended Current:** DC Reverse (+) or AC

Diameter (mm)	1/16 (1.6)	5/64 (2.0)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	25	30	55	75	90
Maximum Amperage	35	50	75	110	140

**Welding Techniques:** Material to be welded should be clean of all contaminants. Maintain a short arc and use stringer beads rather than a weave technique.

**Welding Positions:** Flat, Horizontal, Vertical up, Overhead

**Deposition Rates:**

Diameter (mm)	Length (mm)	Weldmetal/ Electrode	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition min/lb (kg)	Amperage Settings	Recovery Rate
1/16 (1.6)	10" (250)	.13oz (3.6g)	125 (275)	55 (121)	30	100%
5/64 (2.0)	12" (300)	.14oz (4g)	114 (251)	47 (103)	40	100%
3/32 (2.5)	12" (300)	.3 oz. (9g)	50 (109)	35 (76)	65	100%
1/8 (3.25)	14" (350)	.7oz (20g)	22 (49)	21 (46)	95	100%
5/32 (4.0)	14" (350)	1 oz (29g)	15 (33)	18 (40)	120	100%

## APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	1/16 (1.6)	5/64 (2.0)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Length (mm)	10" (250)	12" (300)	12" (300)	14" (350)	14" (350)
Electrodes / lb	67	42	28	13	9
Electrodes / kg	147	92	62	29	20