

## Classifications

EN ISO 3581-A	AWS A5.4
E 19 12 3 L R	E316L-17

## Characteristics and typical fields of application

Avesta 316L/SKR is a Cr-Ni-Mo electrode for all position welding of 1.4436/ASTM 316 type stainless steels.

### Corrosion resistance:

Excellent resistance to general, pitting and intergranular corrosion in chloride containing environments. Intended for severe conditions, e.g. in dilute hot acids.

## Base materials

Outokumpu	EN	ASTM	BS	NF	SS
4436	1.4436	316	316S33	Z7 CND 18-12-03	2343
4432	1.4432	316L	316S13	Z3 CND 17-12-03	2353
4429	1.4429	S31653	316S63	Z3 CND 17-12 Az	2375
4571	1.4571	316Ti	320S31	Z6 CNDT 17-12	2350

## Typical analysis of all-weld metal (wt.-%)

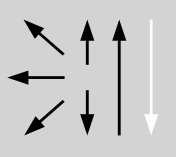
	C	Si	Mn	Cr	Ni	Mo
wt-%	0.02	0.8	0.7	18.0	12.0	2.8

## Mechanical properties of all-weld metal

Heat-treatment	Yield strength R <sub>e</sub> N/mm <sup>2</sup>	Tensile strength R <sub>m</sub> N/mm <sup>2</sup>	Elongation (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J			Hardness
				+20 °C	-40°C	-196°C	
u	460	590	36	60	55	27	210

u untreated, as-welded

## Operating data

	Polarity: DC (+)	Electrode identification:	ø (mm)	L mm	Amps A
			1.6		25 – 50
			2.0		30 – 60
			2.5		45 – 80
			3.25		70 – 120
			4.0		90 – 160
			5.0		150 – 220

## Approvals

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