

Avesta 316L/SKR

Stick electrode

Classifications

high-alloyed

EN ISO 3581-A:

AWS A5.4:

E 19 12 3 LR

E316L-17

Characteristics and field of use

Avesta 316L/SKR is an all position Cr-Ni-Mo electrode for welding ASTM 316 and 316L stainless steels.

Base materials

For welding steels such as					
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
0.02	0.8	0.7	18.0	12.0	2.8

Mechanical properties of all-weld metal

Heat Treatment	Yield strength 0.2%	Tensile strength	Elongation ($L_0=5d_0$)	Impact values in J CVN		
	MPa	MPa	%	+20°C:	-40°C:	-196°C:
untreated	460	590	36	60	55	27

Operating data

Polarity = + / ~

Dimensions (mm)	Amperage 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