

Shielded Metal Arc Welding

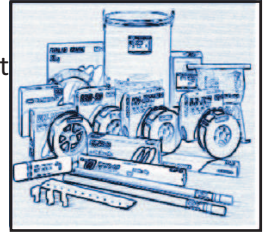
ANU BOND -2C (E 316L - 16)

AWS:SFA 5.4, E316 L-16 IS:5206 E 19-12-2L R 26

Stainless Steel Electrodes

Application :

Suitable of welding AISI 326L and 317L type of stainless steel Application in chemical plant paint, pulp paper and textile industries.



Characteristics on Usage :

An extra low carbon basic coated all position 18 Cr, 12 Ni, 2 Mo stainless steel electrode for welding AISI 316-L equivalent grades of stabilized steel and non stabilized chromium nickle steel which are resistance to atmospheric corrosion of the 316 type. It is very smooth running with extremely smooth removal slag leaving a uniform and fine rippled bead characterized by excellent all round performance and weld metal properties.

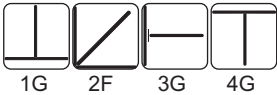
Chemical composition of All-Weld metal (%) as per AWS

C	Mn	Si	S	P	Cr	Ni	Mo
0.040 Max	0.50-2.50	1.0 Max	0.030 Max	0.040 Max	17.0-20.0	11.0-14.0	2.0-3.0

Mechanical properties of all-weld metal as per AWS

UT.S (N/mm ²) 490 Min	Elongation (L=4d) % 30 Min
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Welding Positions



Packaging & Welding Current

SIZE (mm)	KG Per Packet	KG Per Carton	Current (Amps)	In Amps
2.50 x 350	2	12	DC (+)	45-85
3.15 x 350	2	12		85-115
4.00 x 350	2	12		100-140
5.00 x 350	2	12		140-180

