

**Shielded Metal Arc Welding**

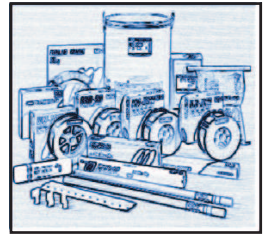
**ANU BOND - 2A (E 316 L -16)**

AWS: SFA 5.4, E 316 L - 16, IS: 5206 E 19 - 11 -2R 24

Stainless Steel Welding Electrodes

**Application :**

For welding all type of stainless steel. Tanks, coils & vats used in the pulp, paper & textile industry. Chemical mixers, paint, dye industries.



**Characteristics on Usage :**

This is the rutile coated electrode, the weld metal has excellent creep strength and is of radiographic quality. It is capable of depositing 316 type of weld metal with normal content the electrode can be manipulated easily in all welding position.

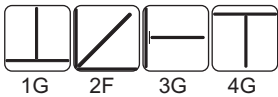
**Chemical composition of All-Weld metal (%) as per AWS**

C	Mn	Si	P	S	Cr	Ni	Mo
0.080 Max	0.50-2.50 Max	1.00 Max	0.040 Max	0.030 Max	17.0- 20.0	11.0-14.0	2.0 - 3.0

**Mechanical properties of all-weld metal as per AWS**

UTS (N/mm <sup>2</sup> )	Elongation ( L=4d ) %
520 Min	30 % Min

**Welding Positions**



**Packaging & Welding Current**

SIZE (mm)	Kg / Packet	Kg. Per Carton	Current (Amps)	In Amps
2.50 x 350	2	12	AC/ 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

