

AK E316-16

Description: AK-E316-16 is a rutile coated Cr18Ni12Mo2 stainless steel electrode. AC and DC dual-use, can perform all-position welding. The welding process performance is excellent, and the deposited metal has good corrosion resistance, heat resistance and crack resistance, especially against chloride ion pitting corrosion.

Application: It is suitable for welding 06Cr17Ni12Mo2 stainless steel equipment working in organic and inorganic acid (non-oxidizing acid) medium; it can also be used for welding high chromium steel and dissimilar steel that cannot be heat treated after welding.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Mo	Cr	Cu
Requirement	0.08	1.00	0.5-2.5	0.03	0.03	11.0-14.0	2.0-3.0	17.0-20.0	0.75
Actual Result	0.04	0.68	0.96	0.010	0.028	11.65	2.41	18.47	0.08

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥ 520		≥25	
Actual Result	595		42	

Recommended welding parameters:

Diameter/mm		2.5	3.2	4.0
Welding current /A	F/H	60-80	80-120	100-150
	V/ OH	40-70	60-100	80-130