

AK E316L-16

Description: A super-low carbon stainless steel electrode designed to weld Cr18Ni12Mo2 steels. With excellent operation and processing properties. The deposited metal carbon content is $\leq 0.04\%$, so the performance of heat resistance, corrosion resistance, and crack resistance is excellent..

Application: Used to weld 06Cr18Ni 12Mo2 type steel, dissimilar steels, and high chromium steel which can not be heated after welding.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Mo	Cr	Cu
Requirement	0.04	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	0.021	0.62	0.65	0.005	0.020	12.75	2.23	19.22	0.25

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥ 490		≥ 25	
Actual Result	620		37	

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