



# PRODUCT DATA SHEET

## STAINLESS STEEL ELECTRODES

WCD 6116

### Staincord 316L-16



#### SUMMARY

- > All Positional, Rutile Type Stainless Steel Electrode
- > Moisture Resistant "Colour Coated" Flux Coating
- > Extra Low Carbon Weld Deposit
- > For the Critical Welding of Matching Type 316 and 316L Steels

#### IDENTIFICATION

**Coating** - Pink **Tip** - Green **Imprint** - WIA 316L-16

#### CLASSIFICATION

- > AS/NZS 4854-B - ES316L-16
- > AWS A5.4: E316L-16

#### DESCRIPTION AND APPLICATION

New generation Staincord 316L-16 is an extra low carbon, rutile type electrode exhibiting superior all positional (except vertical down) performance with an improved moisture resistant "Pink" flux coating for weld metal of high radiographic integrity. The smooth arc action of Staincord 316L-16, together with low spatter and excellent slag control/detachability, promotes exceptional weld appearance and profile. Other features include high arc stability and easy restriking on low voltage AC welding machines.

Staincord 316L-16 deposits Molybdenum bearing, 19Cr/12Ni/2.5Mo filler metal to meet the requirements for welding type 316 and 316L stainless steels in critical applications. Staincord 316L-16 is also recommended for the general purpose welding of common 300 series stainless steels, such as 301, 302, 304 and 304L. It is also suitable for the general welding of ferritic stainless steel alloys, such as 409, 444 and 3Cr12.

#### OPERATIONAL DATA

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	WELDING CURRENT RANGE *(A)	ARC VOLTAGE RANGE **(V)
2.0	300	30 - 50	20
2.5	300	50 - 75	21
3.2	350	75 - 110	26

\*Recommended for DC +/- or AC (minimum 45 OCV) operation.  
 \*\*Voltage is determined by arc current and electrode arc length.  
 Arc voltage shown is typical and is only to be used as a guide.

#### TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	Fe
0.02	0.74	0.71	17.97	12.48	2.37	Bal

#### TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Yield Stress	380 MPa
Tensile Strength	600 MPa
Elongation	40%

#### PACKAGING DATA

ELECTRODE SIZE (MM)	PACKAGING (KG)		APPROX. NO. OF RODS PER KG	PART NO.
	PACKET	CARTON		
2.0	2.5	12.5	84	SC31620
2.5	2.5	12.5	55	SC31625
3.2	2.5	12.5	28	SC31632

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welding.com.au 1300 300 884