

## MIDALLOY CHROMAX E316L-16 COATED ELECTRODE

### CLASSIFICATION

- AWS 5.4 Class E316L-16 ASME SFA 5.4 Class E316L-16 ASME Sec. IX, F4, A8

### DESCRIPTION

- MIDALLOY CHROMAX E316L-16 is AC-DC titania coated electrode
- UNS W31613
- ISO 3518B comparison classification ES316L

### APPLICATION

- For welding or repairing alloy 316L
- Overlay of Carbon and low alloy steels to achieve a Cr-Ni Mo stainless steel (E309L-16 and E316L-16).
- Deposit composition of E316L has Chromium, Nickel and Molybdenum for better corrosion resistance than E308L-16
- Low Ferrite E316L-16 has been used for low temperature (cryogenic) service.

### TYPICAL CHEMISTRY

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	N
.03	19.5	13.3	2.75	1.7	.50	.020	.010	.10	.06

### FERRITE CONTENT 5-12 WRC 1992

### TYPICAL MECHANICAL PROPERTIES (as welded all weld metal)

TENSILE STRENGTH	77,500 PSI
YIELD STRENGTH	60,500 PSI
ELONGATION IN 2"	38%

### RECOMMENDED WELDING PARAMETERS

DIAMETER	AMPERAGE	
	FLAT	VERTICAL & OVERHEAD
3/32"	70-85	65-75
1/8"	85-110	80-90
5/32"	110-140	100-120
3/16"	120-160	110-130

### STANDARD PACKAGING

3/32" 8 lb. can / 48 lb. carton  
 1/8", 5/32", and 3/16" 10 lb. can / 60 lb. carton

8/5/11

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