

Arosta® 316L

TOP FEATURES

- Molybdenum level min. 2.7%
- High resistance to general and intergranular corrosion
- Smooth weld appearance
- Easy slag release
- Strong electrode coating

CLASSIFICATION

AWS A5.4 E316L-16
EN ISO 3581-A E 19 12 3 L R 12

CURRENT TYPE

AC/DC(+/-)

WELDING POSITIONS

All position, except vertical down

APPROVALS

ABS	LR	BV	DNV	TÜV	DB
+	+	+	+	+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	Cr	Ni	Mo	FN (acc.WRC 1992)
0.02	0.8	0.8	18.0	11.5	2.85	4-10

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)		
					+20°C	-20°C	-120°C
Required: AWS A5.4		not specified	min. 490	min. 30	not specified		
EN ISO 3581-A		min. 320	min. 510	min. 25	not specified		
Typical values	AW	450	580	39		60	40

AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
1.5 x 250	20-40
2.0 x 300	30-50
2.5 x 350	40-75
3.2 x 350	60-110
4.0 x 350	80-150
5.0 x 350	140-220

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
1.5x250	PE Tube	145	1.0	529159-1
2.0x300	CBOH	170	1.9	529173-1
2.5x350	SRP	10	0.2	515236-1
	SRP	69	1.4	530001-1
	CBOH	100	2.0	529180-1
3.2x350	SRP	56	1.8	530032-1
	CBOX	130	4.3	529487-1
4.0x350	CBOX	84	4.5	529593-1
5.0x350	CBOX	50	4.1	529708-1

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.