NOUVE® 316L-16

Designation

AWS A5.4 E316L
UNS No. W31613

Welding Positions

Features

- Excellent arc characteristics
- Low spatter level
- Quick & easy slag removal
- Low moisture re-absorption
- Low smoke level
- Radiography quality

Applications

Used extensively in molybdenum bearing austenitic stainless steels.
Joining of 316L and also dissimilar welding.

Recommended Welding Techniques

GENERAL : Electrode positive, work negative (DCEP)
ARC LENGTH : Short arc
STORAGE : Re-dry electrodes 250°C to 300°C for 1 hour before use.

Weld Metal Chemistry

	Carbon	Chromium	Nickel	Molybdenum	Nb+Ta	Manganese	Silicon	Phosphorous	Sulphur	Copper
AWS	0.04	17-20	11-14	2-3	-	0.5-2.5	0.5-2.5	0.04	0.03	0.75
Typical	0.032	18.80	13.24	2.06	-	2.12	0.78	0.024	0.022	0.62

Mechanical Properties (as welded)

MECHANICAL TESTS	Tensile Strength	Elongation % in 2”
AWS SPEC	490	30
TYPICAL	540	34

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