



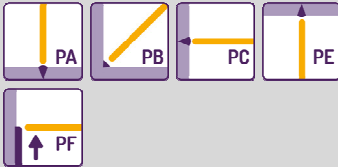
Soldyrec

Processing information

Whether preheating is required depends on the base material, otherwise not necessary. Interpass temperature max. 150 °C.

Re-drying: 300-350 °C/2h

Welding positions:



Polarity:



STICKELECTRODES, STAINLESS-RESISTANT

SOLDY 308L16

Application

Electrode for joint welding on low-carbon, unstabilised and stabilised austenitic, chemically stable chromium-nickel steel at working temperatures of up to 350 °C, for corrosion-resistant chromium steel, for cold-tough austenitic steel as well as claddings of similar alloys.

Field



Characteristic
rutile-coated,
core wire-alloyed

Standards
ISO 3581-A
E 199 LR 12
AWS A 5.4
E 308 L-16

Material no.
1.4316

Approvals



Materials

1.4301 X5CrNi18-10	1.4541 X6CrNiTi18-10
1.4306 X2CrNi19-11	- AISI 304 AISI 304L AISI 304LN AISI 321
1.4311 X2CrNiN18-10	

All Weld Metal Mechanical Properties

Heat Treatment	AW			
Structure	Austenite with approx. 8% ferrite			
Weld Metal Composition [%]				
C	Si	Mn	Cr	Ni
0,02	0,9	0,8	19,5	9,5
Yield Strength Rp 0,2 [MPa]		> 350		
Tensile Strength Rm [MPa]		> 550		
Elongation A5 [%]		> 35		
Charpy Impact Value ISO-V [J/RT]		> 70		

Welding Current - Packaging

Item no.	Diam. [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
	2,00/300	60 - 80	4,0	348	11,5
	2,50/300	80 - 100	4,0	221	18,1
	3,25/350	100 - 130	5,0	139	36,0
	4,00/350	120 - 160	5,0	91	54,9
	5,00/450	160 - 200	6,0	55	109,1

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