

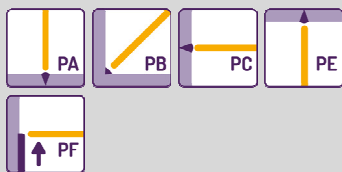


Soldyrec

Processing information

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



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

Materials

1.4401 X5CrNiMo 17-12-2	1.4435 X2CrNiMo 18-14-3
1.4404 X2CrNiMo 17-12-2	1.4436 X3CrNiMo 17-13-3
1.4406 X2CrNiMoN 17-11-2	1.4571 X6CrNiMoTi 17-12-2
1.4408 GX5CrNiMo 19-11-2	1.4580 X6CrNiMo- Nb 17-12-2
1.4409 GX2CrNiMo 19-11-2	1.4429 X2CrNiMoH 17-13-03
- AISI 316 AISI 316L AISI 316Cb AISI 316Ti	

STICKELECTRODES, STAINLESS-RESISTANT

SOLDY 316L16

Application

Electrode for joint welding on low-carbon, unsta-bilised and stabilised austenitic, chemically stable chromium-nickel-molybdenum steel at working temperatures of up to 400 °C. This stainless steel electrode is also suitable for claddings of similar alloys.

Field



**Characteristic
rutile-coated,
core wire-alloyed**

**Standards
ISO 3581-A
E 19123LR12**

**AWS A 5.4
E 316 L-16**

**Material no.
1.4430**

Approvals



All Weld Metal Mechanical Properties

Heat Treatment	AW				
Structure	Austenite with approx. 8% ferrite				
Weld Metal Composition [%]					
C	Si	Mn	Cr	Ni	Mo
0,02	0,9	0,8	19	12,5	2,7
Yield Strength Rp 0,2 [MPa]		> 350			
Tensile Strength Rm [MPa]		> 550			
Elongation A5 [%]		> 30			
Charpy Impact Value ISO-V (J/RT)		> 60			

Welding Current, Packaging

Item no.	Diam.[mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
	1,60/250	40 - 60	3,0	500	6,0
	2,00/300	60 - 80	4,0	348	11,5
	2,50/300	80 - 100	4,0	220	18,2
	3,25/350	100 - 130	5,0	139	36,0
	4,00/350	120 - 160	5,0	93	53,8
	5,00/450	160 - 200	6,0	55	109,1



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