

NST E 316L

AWS A5.4: E 316L-17

EN ISO 3581-A: E 19 12 3 LR 12



Rutile electrode for welding stainless 316 steels.

General description:

NST E 316L is an austenitic rutile, low carbon electrode for welding non-stabilised and stabilised stainless steels. Resistant to inter-granular corrosion up to 350 °C, resistant to oxidation up to 800°C, and good low-temperature ductility down to -120°C. Excellent welding properties in all welding positions, except vertical down (PG). Also suitable for 304 steels.

This product is delivered in a premium vacuum-pack, with smart 2-in-1 packaging.

VacuumPack SuperDry 2-in-1

Welding positions:



Welding current:

DC+/AC

Redrying:

300 °C/2 hours

Typical chemical composition of all-weld-metal:

C	Si	Mn	P	S	Cr	Ni	Mo		
≤0,03	0,80	0,70	<0,030	<0,025	18,5	11,5	2,7		

Ferrite content:

FN≈8

Mechanical properties of all-weld-metal:

Yield and Tensile Strengths			Charpy Impact Test	
Yield Mpa	Tensile Mpa	Elongation %	Charpy V (J) +20 °C	
≥320	≥510	≥30	≥47	

Guidance - Ampere (DC+/AC):

Electrode diameter	2,5 mm	3,2 mm	4,0 mm
Ampere / Volt	50-85	70-125	110-165

Packaging information:

2,0mm x 300mm x 16,2 kg (SuperDry 2-in-1 packs, 2 x 0,9kg)
2,5mm x 300mm x 14,4kg (SuperDry 2-in-1 packs, 2 x 0,8kg)
3,2mm x 350mm x 16,0kg (SuperDry 2-in-1 packs, 2 x 0,8kg)
4,0mm x 350mm x 10,0kg (SuperDry 2-in-1 packs, 2 x 0,5kg)

Approvals:

TÜV, CE

Reference / date:

NST E 316L,
English, 24.08.2018.

Perfect Welding

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