

COVERED ELECTRODES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SS-316 is a titanium oxide low hydrogen electrode, the weld metal contains 18%Cr-12%Ni-2%Mo the austenitic structure.
- It is suitable for Chemical Container as AISI 316/316L, SUS 316/316L steels.

NOTE ON USAGE :

- Re bake the electrodes at 250 ~ 300°C for 1 hour and keep it at 100~150°C prior to use.
- With lower current is to properly keep the dilution of the parent metal for welding crack.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Ni	Cr	Mo
0.040	1.26	0.60	0.030	0.005	12.10	18.70	2.30

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %
580(59.2)	40

SIZE AND RECOMMENDED CURRENT RANGE : AC or DC(+)

Diameter (mm)		2.6	3.2	4.0	5.0
Length (mm)		300	350	350	350
Current (Amp)	F	50-85	80-120	100-150	140-180
	V & OH	45-80	70-110	90-135	-