



LA316L

STANDARD

AWS A5.22 E316L T1-1 ; E316L T1-4

CHARACTERISTICS

Excellent operating properties, good appearance and slight spatter, corrosive resistance

APPLICATION

For welding 18-12 Mo2 stainless steel (SUS 316L) of extra low carbon, with excellent operating performance, especially against intergranular corrosion.

TYPICAL CHEMICAL COMPOSITION (%)

C	Mn	Si	Cr	Ni	Mo	S&P
0.029	1.33	0.57	18.35	12.49	2.42	≤0.03

MECHANICAL PROPERTIES: (CO2 SHIELDED)

Strength of Extension σ_b (Mpa)	Ductility δ_5 (%)
≥480	≥35
516	44

WELDING PROCEDURE PARAMETERS

Diameter(mm)	Amperage(A)	Voltage(V)
Φ1.2	140-260	24-32
Φ1.6	200-300	27-34

NOTES

1. CO2 purity≥99.5% , gas-flow≥20L/Min.
2. Deposited metal is unmachinable.
3. Pay attention to wind-resistance.
4. Remove the greasy dirt and moisture.