

Standards:

EN 1600:1997: : E 19 12 3 L R 1 2
 AWS A5.4: : E 316L-16

UTP 316L- 16

SMAW stick electrode, high-alloyed,
 chemical resistant

Application field

Special type low carbon rutile-basic coated stainless steel electrode particularly designed for site welding of thin walled tubes and sheets. The very stable arc produces an excellent root penetration, bead configuration and gap bridging ability on DC electrode negative even when welding with a low amperage. **UTP 316L-16** is a good economical alternative to GTAW welding on difficult accessible on-site welding applications. The product is resistant to intergranular corrosion up to service temperatures of +400 °C.

Base Materials

1.4401 X5CrNiMo17-12-2, 1.4404 X2CrNiMo17-12-2, 1.4435 X2CrNiMo18-14-3,
 1.4436 X3CrNiMo17-13-3, 1.4571 X6CrNiMoTi17-12-2, 1.4580 X6CrNiMoNb17-12-2,
 1.4583 X10CrNiMoNb18-12, 1.4409 GX2CrNiMo 19-11-2

Typical Composition of All-weld Metal

Mechanical properties of the weld metal

Tensile Strength MPa	Elongation (l = 4d) %
> 490	>30

Weld metal analysis in %

C	Cr	Ni	Mo	Mn	Si	Cu
< 0,04	17,0 – 20,0	11,0 – 14,0	2 – 3	0,5 – 2,5	< 1,00	< 0,75

Current type:	(= +)	(~)
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Welding positions

Current adjustment

Electrodes	Ø x L(mm)	2.4mm (3/32") x 300	3.2mm (1/8") x 350	4.0mm (5/32") x 400
Amperage A		60-80	80-120	100-130