E316-16

DESCRIPTION: Weldcote Metals E316-16 electrodes are designed for welding wrought and cast forms of similar composition. The presence of molybdenum increases the creep resistance at elevated temperatures and offers good resistance to pitting corrosion. Applications include welding of equipment for chemical and process industries.

APPROVALS: Manufactured under Quality System approved by ASME, IS09001. Meets AWS 5.4 Class E316-16.

CHEMICAL COMPOSITION

Carbon	.055
Manganese	1.7
Silicon	.56
Chromium	18.85
Nickel	12.90
Molybdenum	2.35
Sulfur	.024
Phosphorus	.025
Iron	Balance

MECHANICAL PROPERTIES

Tensile Strength

87,500 PSI 600 MPA

Yield Strength

58,500 PSI 400 MPA

Elongation 36%

WELDING PARAMETERS

Direct Current
Electrode + Ve

AMPERAGES:

3/32"	65-75
1/8"	90-105
5/32"	120-135
3/16"	135-155

(For vertical welding amperages are to be reduced by 10 to 15 amps)