



## E316L-16



**DESCRIPTION:** The weld deposit of Weldcote Metals E316L-16 electrodes is similar to that of Type E316-16, except the carbon is limited to a maximum of 0.04%. Precise control of the carbon content in Weldcote Metals E316L-16 electrodes provides a weld deposit matching the corrosion resistant qualities of Type 316L stainless steel. The extra low carbon content reduces the possibility of carbide precipitation and consequent intergranular corrosion.

**APPROVALS:** Manufactured under Quality System approved by ASME, IS09001. Meets AWS 5.4 Class E316L-16.

### CHEMICAL COMPOSITION

|            |         |
|------------|---------|
| Carbon     | .035    |
| Manganese  | 1.75    |
| Silicon    | .52     |
| Chromium   | 18.70   |
| Nickel     | 12.65   |
| Molybdenum | 2.30    |
| Sulfur     | .022    |
| Phosphorus | .024    |
| Iron       | Balance |

### MECHANICAL PROPERTIES

#### **Tensile Strength**

85,500 PSI                      590 MPA

#### **Yield Strength**

58,000 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)

Weldcote Metals believes this data to be accurate and to reflect qualified expert opinion regarding current research. However, Weldcote Metals can not make any expressed or implied warranty as to this information.