

ES 316L-15

Type Basic

SMAW

E316L-15

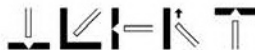
ESWECO
The Art of Welding

Description

ES 316L-15 is a low-carbon, basic, stainless electrode designed for welding steel of the 18Cr12Ni3Mo type. The high impact toughness at cryogenic temperatures (-196°C) makes ES 316L-15 excellent in LNG applications. The weld metal is very resistant to cracking and porosity. ES 316L-15 has outstanding welding properties in the vertical and overhead positions.

Current

DC+



Classifications

EN 1600	E 19 12 3 L B 2 2
SFA/AWS A5.4	E316L-15
Werkstoff Nr.	1.4430

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
<0.04	0.5	1.7	18.5	12.0	2.8	<0.3

Typical mech. Properties all weld metal

Yield stress, MPa	430
Tensile strength, MPa	560
Elongation A4, %	40

Charpy V

Test temps, °C	Impact values, J
+20	95
-60	75
-120	60
-196	35

Ferrite content FN 3-8

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	350	55-85	24
3.2	350	75-110	24
4.0	350	110-150	24
5.0	350	150-200	24