

EASYARC™ 316L**CONFORMANCE**

- AWS A5.4/ASME SFA5.4: E316L-17
- GB 983: E316L-17

WELDING POSITIONS**APPLICATION**

- It is for all position welding of Cr-Ni-Mo austenitic stainless steel ASTM 316, 316L or equivalent steels.

FEATURES

- Rutile-Basic stainless steel electrode
- Weldable on AC and DCEP
- Excellent weldability, Smooth bead appearance
- High resistance to weld porosity
- Low susceptibility to hot cracking
- High resistance to general corrosion and intergranular corrosion

* Please contact the local customer service for more package types.

REDRYING

- For electrodes that have had a short or mild exposure to the atmosphere then re-drying at 300°C for 1 hour will be sufficient. For electrodes that have been exposed to longer or more aggressive conditions or for critical work redrying at 300-350°C for 1-2 hours is recommended. After redrying electrodes should be stored in a hot box.

EASYARC™ 316L**DIAMETERS/PACKAGING**

Diameter × Length (mm × mm)	Inner box	Package - Weight (kg)	Outer Carton
2.5 x 300	4		16
3.2 x 350	5		20
4.0 x 350	5		20
5.0 x 350	5		20

ALL WELD METAL MECHANICAL PROPERTIES -- TYPICAL

Electrode	Condition	Tensile Strength (Mpa)	Elongation (%)
AWS E316L-17 Required	As-welded	≥490	≥30
GB E316L-17 Required	As-welded	≥490	≥30
EASYARC™ 316L	As-welded	600	41.5

ALL WELD METAL CHEMICAL COMPOSITIONS (Wt-%) -- TYPICAL

Electrode	C	Cr	Ni	Mo	Mn	Si	P	S	FN
AWS E316L-17 Required	≤0.04	17.0-20.0	11.0-14.0	2.0-3.0	0.5-2.5	≤1.00	≤0.04	≤0.03	—
GB E316L-17 Required	≤0.04	17.0-20.0	11.0-14.0	2.0-3.0	0.5-2.5	≤0.90	≤0.04	≤0.03	—
EASYARC™ 316L	0.022	19.34	12.01	2.59	0.71	0.75	0.025	0.006	7-10

RECOMMENDED WELDING CURRENT (CURRENT POLARITY: DC+ & AC)

Diameter × Length (mm × mm)	Welding Position	2.5 x 300	3.2 x 350	4.0 x 350	5.0 x 350
Current (A)	1G, 2G, 2F	50-85	80-120	100-150	140-180
	3G up, 4G	45-80	70-110	90-140	—

Customer Assistance Policy

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to change - This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com.cn for any updated information.

Authorized Distributor:

THE NANJING LINCOLN ELECTRIC Co., LTD

No.2, Qiande Road, Jiangning Science Park, Jiangning District, Nanjing, Jiangsu, China 211100

TEL: +86-25-8645 2736 8418 8377

FAX: +86-25-8641 8809

www.lincolnelectric.com.cn