

**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.

**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.

**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.

**EASYARC™ 316L****DIAMETERS/PACKAGING**

Diameter × Length (mm × mm)	Package - Weight (kg)	
	Inner box	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**

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