



Cromarod 316L-140

SMAW - (Stick) - MMA
Stainless Steel

Date: 05/30/2013
Revision: 18

Description:

Cromarod 316L-140 is a rutile flux coated, high deposition electrode with a stainless core wire and 140% recovery. The electrode is intended for welding in the downhand and horizontal-vertical positions and is especially suitable for high productivity welding of medium to heavy section 18% Cr / 12% Ni / 2.5% Mo austenitic stainless steels. Operability is excellent producing smooth weld beads, slightly concave profile fillet welds, negligible spatter and self-releasing slag. Cromarod 316L-140 is also suitable for welding the stabilised material grades 347 and 321 if used at service temperatures below 400 °C.

Welding positions:



Coating type:

Rutile, high recovery 140%

Welding current:

DC+, AC OCV > 39V

Ferrite content:

FN 8 (WRC-92)

Corrosion resistance

Good resistance to general and intergranular corrosion in the more severe environments e.g. dilute hot acids. Good resistance to chloride pitting corrosion.

Scaling temperature:

Approx. 800 °C in air.

Redrying temperature:

350 °C, 2h

Chemical composition, wt. %

	C	Si	Mn	P	S	Cr	Ni
Min			0,5			17,0	11,0
Typical	0,02	0,8	0,8	0,02	0,02	18,4	11,8
Max	0,030	0,90	2,0	0,030	0,025	20,0	13,0

	Mo	Cu	V	Nb
Min	2,5			
Typical	2,7	0,1		
Max	3,0	0,5	0,1	0,1

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 350 MPa	490 MPa
Tensile Strength, Rm:	≥ 510 MPa	600 MPa
Elongation, A5	≥ 30%	35%
Impact energy, CV:		20 °C • 60 J

Classification:

AWS A5.4 E 316L-17
ISO 3581-A E 19 12 3 L R 53

Approvals:

CE
DNV

Note

Core wire:
P ≤ 0.020%
S ≤ 0.015%
N ≤ 0.080%

Produkt data:

Diam.mm	Length mm	Product code	Current A	Voltage V	Kg weld metal/ kg electrodes	No. of electrodes/	Kg weld metal/ hour arc time	Burn-off time/ electrode (sec.)

						kg weld metal		
2,5	300	74422500	60-90	32	0,67	61,0	1,4	42
3,2	350	74423200	110-130	34	0,77	27	2,2	62
4,0	450	74424000	130-170	38	0,77	14	3	70
5,0	450	74425000	170-230	40	0,77	9	4,3	80