

316L/SKR-PW AC/DC

For welding steels such as Outokumpu	EN	ASTM	BS	NF	SS
4436	1.4436	316	316S33	Z7 CND 18-12-03	2343
4432	1.4432	316L	316S13	Z3 CND 17-12-03	2353
4429	1.4429	S31653	316S63	Z3 CND 17-12 Az	2375
4571	1.4571	316Ti	320S31	Z6 CNDT 17-12	2350

Standard designations

EN 1600 E 19 123 L R
 AWS A5.4 E316L-17

Characteristics and welding directions

AYESTA 316L/SKR-PW is a Cr-Ni-Mo electrode with a coating optimised for the vertical-up and overhead position welding of ASTM 316 and 316L stainless steels.

Thanks to the sharp and concentrated arc, PW electrodes are extremely suitable for maintenance and repair welding, especially when joint surfaces are not particularly clean.

Welding data

DC+ or AC	Diameter, mm	Current, A
	1.60	20 – 45
	2.00	25 – 60
	2.50	35 – 80
	3.25	60 – 120
	4.0	100 – 160
	5.0	160 – 220

Weld deposit data at maximum welding current

Electrode diam. length		Metal recov.				
mm	mm	N	B	H	T	~%
1.6	250	0.62	274	0.55	24	109
2.0	250	0.63	176	0.69	29	108
2.5	300	0.67	92	0.99	40	107
3.25	350	0.63	45	1.60	50	107
4.0	350	0.64	30	2.17	55	107
5.0	350					

Chemical composition, wire (typical values, %)

C	Si	Mn	Cr	Ni	Mo
0.02	0.8	1.0	18.0	12.0	2.8

Ferrite 10 FN DeLong

Mechanical Properties

	Typical values (IIV)	Min. values EN 1600
Yield strength $R_{p0.2}$	455 N/mm ²	320 N/mm ²
Tensile strength R_m	590 N/mm ²	510 N/mm ²
Elongation A^5	36 %	25 %
Impact strength KV		
+20°C	60 J	
-40°C	60 J	
Hardness	210 Brinell	

Interpass temperature: Max. 150°C.

Heat input: Max. 2.0 kJ/mm.

Heat treatment: Generally none (in special cases quench annealing at 1050°C).

Structure: Austenite with 5 - 10% ferrite.

Scaling temperature: Approx. 850°C (air).

Corrosion resistance: Excellent resistance to general, pitting and intercrystalline corrosion in chloride containing environments. Intended for severe conditions, e.g. in dilute hot acids.

Approvals

•CE •CWB •DB •DNV •TÜV

Welding positions

Ø 1.6–3.25 Ø 4.0–5.0

