

# Vertarosta® 316L

## TOP FEATURES

- Specially developed for vertical down welding on DC
- Root passes in grooves with root opening
- High general corrosion resistance
- Molybdenum level min. 2.7 %

## CLASSIFICATION

AWS A5.4 E316L-15  
EN ISO 3581-A E 19 12 3 L R 2 1

## CURRENT TYPE

AC/DC+

## WELDING POSITIONS

Vertical down

## APPROVALS

TÜV

+

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	Cr	Ni	Mo	FN (acc. WRC 1992)
0.02	0.7	0.85	18.0	11.5	2.8	4-10

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

As welded		AWS A5.4	EN ISO 3581-A	Typical
Tensile strength	(MPa)	min. 490	min. 510	620
0.2% Proof strength	(MPa)	not specified	min. 320	500
Elongation	(%)	min. 30	min. 25	35
Impact ISO-V (J)	+20°C	not specified	not specified	50
	-20°C	not specified	not specified	45
	-60°C	not specified	not specified	35

## OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	60-70
3.2 x 300	80-110

## PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	CBOH	95	1.6	558098-1
3.2 x 300	CBOH	60	1.7	558104-1

## TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.  
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