

# Limarosta 316L

## Key Features

- All positional Electrode (except vertical down) suitable for welding 300 series stainless steel.
- Excellent wetting characteristics.
- High resistance to porosity.

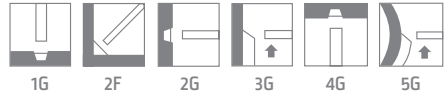
## Typical Applications

- Suitable for root pass.
- Stainless steel pipe and structural applications.

## Conformances

**AWS A5.4:** E316L-17  
**AS/NZS 4854-A:** E 19 12 3 L R 12

## Welding Positions



## Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
2.5	350	557442-1	CB 2.0 kg (6 x CB per carton)
3.2	350	557466-1	CB 4.2 kg (3 x CB per carton)

## Mechanical Properties

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ +20°C
<b>Requirements - AWS</b>	-	490 min	30 min	-
<b>Requirements - AS/NZS</b>	320 min	510 min	25 min	-
<b>Typical Results - As Welded</b>	440	580	35	60

## Deposit Composition

	%C	%Mn	%Si	%P	%S
<b>Typical Results - As Welded</b>	0.03	0.8	1.00	0.025	0.01
	%Ni	%Cr	%Mo	FN (acc.WRC 1992)	
<b>Typical Results - As Welded</b>	11.5	18.0	2.7	5-10	

## Typical Operation Procedures

Polarity	Current (amps)	
	2.5mm	3.2mm
DC+	70-90	100-120