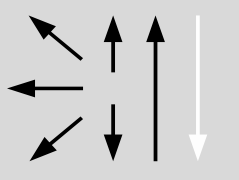


Classification					
AWS A5.4		EN ISO 3581-A		GB/T 983	
E316L-17		E 19 12 3 L R		E316L-17	
Characteristics and typical fields of application					
Avesta 316L-17 is a Cr-Ni-Mo rutile acid electrode for all position welding to ASTM 316 and 316L stainless steel. Produced using fully alloyed wire provide excellent weldability in all position welding and smooth weld bead surface. Weld metal features a good resistance against intergranular corrosion (IGC ASTM A262 Practice E)					
Base Materials					
Outokumpu 4436, 4432, 4429, 4571; EN 1.4436, 1.4432, 1.4429, 1.4571; ASTM 316, 316L, S31653, 316Ti; BS 316S33, 316S3, 316S63, 320S31; NF Z7 CND 18-12-03, Z3 CND 17-12-03, Z3 CND 17-12-Az, Z6 CND 17-12; SS 2343, 2353, 2375, 2350.					
Typical analysis of all weld metal (Wt.-%)					
C	Si	Mn	Cr	Ni	Mo
0,02	0,75	0,65	18,3	12,3	2,6
Ferrite Number ≈ 3-8 FN WRC 92					
Mechanical properties of the weld metal					
Heat Treatment	Yield strength	Tensile strength	Elongation	Impact work	
	R _e N/mm ²	R _m N/mm ²	(L ₀ =4d ₀)	ISO-V KV J	
	MPa	MPa	%	+20°C	-120°C
As Welded	430 (≥ 320)	560 (≥ 510)	40 (≥ 30)	57 (≥ 32)	57 (≥ 27)
Operating Data					
		Polarity DC (+) / AC	Heat Input: Max. 2.0 kJ/mm Interpass temperature: Max. 150°C Scaling Temperature : Approx. 850°C Instruction for Re-drying: Re-dry for 3 h at 250-280°C before using		
Approval					
ABS, DNV-GL, CWB, CE					
Size, Packing and Recommended welding parameters					
Size (mm)	Kg / Pack	Kg / Box	Amperage (A)		
2.50 x 350	5,00	15,00	45-80		
3.25 x 350	5,00	15,00	70-120		
4.00 x 450	5,00	15,00	90-160		
5.00 x 450	5,00	15,00	150-220		