

Classifications

EN ISO 14343-A	EN ISO 14343-B	ASME II C SFA 5.9
B 19 12 3 L	BS316L	EQ316L

Characteristics and typical fields of application

- SOUDOTAPE 316L austenitic stainless steels strip with Mo developed to deposit alloy 316L (19%Cr-12%Ni-3%Mo).
- SOUDOTAPE 316L is to be used in combination with Submerged Arc Welding fluxes RECORD INT 101 or RECORD INT 109 as well with Electroslag fluxes RECORD EST 122 or RECORD EST 136.

To get deposit conform to Alloy 316L, buffer layer is made with over-alloyed SOUDOTAPE 22.11L, 309L or 21.13.3L.

- SOUDOTAPE 316L can also be used in combination with RECORD EST 316-1 to reach the full chemical analysis of alloy 316L in single layer.
- SOUDOTAPE 316L can also be used in combination with RECORD EST 317-2 to reach deposit conform to 317L.
- SOUDOTAPE 316L second layer in combination with RECORD EST130 give deposit similar to stick electrode E318 deposit with reduced risk of intergranular carbide precipitation.

- Used in several industrial segments such as chemical, petrochemical, clad steel constructions where high corrosion resistance is required.

- Typical applications are chemical reactor, pressure vessels, pipes and valves.

Typical analysis

	C	Si	Mn	Cr	Ni	Mo	N	Fe
wt.-%	0.01	0.4	1.7	18.5	12.7	2.9	0.04	Rem.

Typical fluxes to combine

Process	Name	EN ISO 14174
ESW	RECORD EST 122	ES A FB 2B
ESW	RECORD EST 122Mo	ES A FB 2B
ESW	RECORD EST 130	ES A FB 2B
ESW	RECORD EST 136	ES A FB 2B
ESW	RECORD EST 316-1	ES A FB 2B
ESW	RECORD EST 317-2	ES A FB 2B
SAW	RECORD INT 101	S A AB 2B
SAW	RECORD INT 109	S A CS 2B
SAW	RECORD INT 317	S A AB 2B

Packaging

Size(s) in mm	Type	Weight
30 x 0,5	Coil	25 - 30 kg
60 x 0,5	Coil	50 - 60 kg
90 x 0,5	Coil	75 - 90 kg

Other sizes and coil weights on request.