



LZ316L

STANDARD

AWS A5.22 E316L T1-1 ; GB/T 17853 E316L T1-1

CHARACTERISTICS

Excellent operating properties, good appearance and slight spatter, corrosive resistance

APPLICATION

For welding 18-12 Mo2 stainless steel (SUS 316L) of extra low carbon, with excellent operating performance, especially against intergranular corrosion.

TYPICAL CHEMICAL COMPOSITION (%)

C	Mn	Si	Cr	Ni	Mo	S/P
0.029	1.32	0.56	18.37	12.43	2.44	≤0.03

MECHANICAL PROPERTIES: (CO2 SHIELDED)

Strength of Extension σ_b (Mpa)	Ductility δ_5 (%)
≥480	≥35
570	30

WELDING PROCEDURE PARAMETERS

Diameter(mm)	Amperage(A)	Voltage(V)
Φ1.2	140-260	24-32
Φ1.6	200-300	27-34

PACKING

1. 1.2/ 1.6mm: 15kg/spool