

Classifications

EN ISO 3581-A	AWS A5.4
E 19 12 3 L R	E316L-17

Characteristics and typical fields of application

Avesta 316L/SKR-4D is a thin-coated, rutile-acid type electrode specially developed for welding thin-walled pipes and sheets in 1.4436/ASTM 316 type steel, mainly in the chemical process and papermaking industries. It is highly suitable for welding restrained positions and under difficult site conditions, where it offers considerably higher productivity than manual TIG-welding. It is also recommended for root runs and multi-pass welds in general fabrication of ASTM 316-type stainless steels in all material thicknesses.

Corrosion resistance:

Excellent resistance to general, pitting and intergranular corrosion in chloride containing environments. Intended for severe conditions, e.g. in dilute hot acids.

Base materials

Outokumpu	EN	ASTM	BS	NF	SS
4436	1.4436	316	316S33	Z7 CND 18-12-03	2343
4432	1.4432	316L	316S13	Z3 CND 17-12-03	2353
4429	1.4429	S31653	316S63	Z3 CND 17-12 Az	2375
4571	1.4571	316Ti	320S31	Z6 CNDT 17-12	2350

Typical analysis of all-weld metal (wt.-%)

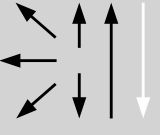
	C	Si	Mn	Cr	Ni	Mo
wt-%	0.02	0.8	0.7	18.2	12.2	2.6

Mechanical properties of all-weld metal

Heat-treatment	Yield strength R_e N/mm ²	Tensile strength R_m N/mm ²	Elongation ($L_0=5d_0$)	Impact work ISO-V KV J		Hardness
	MPa	MPa	%	+20 °C	-20 °C	HB
u	480	590	34	60	55	210

u untreated, as-welded

Operating data

	Polarity: DC (+)	Electrode identification:	ø (mm)	L mm	Amps A
			1.6		15 – 40
			2.0		25 – 55
			2.5		30 – 85
			3.25		45 – 110

Approvals

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