

ASME II C SFA 5.9 : EQ 316L
EN ISO 14343-A : B 19.12.3 L

DESCRIPTION

- SOUDOTAPE 316L is a welding strip especially designed to deposit alloy 316L.
- SOUDOTAPE 316L is to be used in combination with Record INT 101 or Record INT 109 (SAW : Submerged Arc Welding) as well as Record EST 122 or Record EST 136 (ESW : Electroslag Welding). In case of deposits in two layers, the first one is made with SOUDOTAPE 309L.
- SOUDOTAPE 316L can also be used in combination with Record EST 316-1 to reach the full chemical analysis of alloy 316L in one layer ESW.

SUITABLE FOR

- Used in different industrial sectors such as chemical, petrochemical, cladded steel constructions...
- Typical applications are chemical reactor vessels, hydrocrackers...

TYPICAL WELD METAL ANALYSIS OF STRIP/FLUX COMBINATION (WEIGHT%)

- Submerged arc strip cladding with Record INT 101/INT 109 on 0.2% C-steel.

	Flux RECORD	C	Mn	Si	Cr	Ni	Mo	Thick (mm)	FN
SOUDOTAPE 316L		0.014	1.70	0.4	18.30	12.60	2.90	-	-
2 nd Layer	INT 101	0.025	1.50	0.50	18.30	12.20	2.40	3.7	7
2 nd Layer	INT 109	0.029	0.70	0.90	18.40	11.70	2.00	3.5	5

- Electroslag strip cladding with Record EST 316-1/EST 122/EST 136 on 0.2% C-steel.

	Flux RECORD	C	Mn	Si	Cr	Ni	Mo	Thick (mm)	FN
SOUDOTAPE 316L		0.014	1.70	0.4	18.30	12.60	2.90	-	-
1 st Layer	EST 316-1	0.02	1.20	0.30	19.40	12.80	2.60	4.8	6.5
2 nd Layer	EST 122	0.021	1.50	0.60	18.80	12.20	2.40	3.6	7
2 nd Layer	EST 136	0.025	1.40	0.40	18.20	12.0	2.30	3.0	5

AVAILABLE STRIP SIZES

- Standard : 60 x 0.5 mm or 30 x 0.5 mm.
- Other sizes on request.

PACKING

- 60 x 0.5 mm : 50 kg to 60 kg.
- 30 x 0.5 mm : 25 kg to 30 kg.
- Other packing on request.

Note : For additional information about cladding conditions and deposited weld metal properties, please refer to the corresponding flux technical data sheet, cladding data sheet or contact us.