

# spark 316-L

Electrode for joining 316, 316L, 317L,  
318 and similar stainless steels

**Classifications:** AWS A/SFA 5.4: E 316L-16 || IS5206 : E19.12.2 LR26

**Descriptions:** An extra low carbon, rutile type, all position Molybdenum bearing stainless steel electrode used for welding, 18% Cr, 12% Ni, 2.5% Mo type steels. The electrode provides maximum resistance to hot cracking due to low ferrite content and also offers high resistance from stress corrosion cracking and chemical corrosion in chloride ion media. The electrode has excellent welding performance giving smooth beads of excellent appearance.

**Applications:**

- Commonly used in industries where acid resistance upto 300°C is required.
- Welding Chemical tanks of Dye industries, textile industries, paint, paper & pulp industries.
- For corrosion resistant castings and bleaching equipment of chemical industries.
- For tanks and vessels whose surfaces are affected by acids.

**Welding Parameters:**

Size (mm X mm)	Current (Amps)
2.50 x 350	55-80
3.15 x 350	75-110
4.00 x 350	120 - 160

**Typical Mechanical Properties:**

UTS	570 N/mm <sup>2</sup>
Elongation	40 %
Yield Strength	430 N/mm <sup>2</sup>

**Typical All weld metal composition (%):**

C	Mn	Si	Mo	Cr	Ni	S	P
0.03 max	1.05	0.85	2.6	18.9	12.2	0.014	0.03