



CROMAROD® 316LP

SMAW - (Stick) - MMA
Stainless Steel

Date: 2022-05-23
Revision: 28

Description:

CROMAROD 316LP is an all positional rutile coated electrode designed specially for welding thin walled (down to 1.5 mm) pipelines found in the chemical process and papermaking industries, where it offers considerably higher productivity than manual TIG. With its exceptionally good arc stability, weld pool control and restriking characteristics it is highly suitable for the most demanding vertical and overhead welding applications in fixed pipework and is ideal for cramped and difficult site conditions. CROMAROD 316LP is also recommended for root runs and butt welds in general fabrication of molybdenum alloyed stainless steels in all material thicknesses.

Welding positions:



Coating type:

Rutile

Welding current:

DC+

Ferrite content:

FN 4 (WRC-92)

Corrosion resistance

Good resistance to general and intergranular corrosion in the more severe environments e.g. dilute hot acids. Good resistance to chloride pitting corrosion.

Scaling temperature:

Approx. 850 °C in air.

Redrying temperature:

350 °C, 2h

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min			0,5			17,0	11,0
Typical	0,02	0,7	0,8	0,02	0,02	18,3	12,2
Max	0,030	0,90	2,0	0,030	0,025	20,0	13,0

	Mo	Cu	V	Nb
Min	2,5			
Typical	2,7			
Max	3,0	0,5	0,1	0,1

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 320 MPa	480 MPa
Tensile Strength, Rm:	≥ 510 MPa	580 MPa
Elongation, A5	≥ 30%	32%
Impact energy, CV:		20 °C • 60 J -120 °C • 35 J

Product data:

Diam.mm	Length mm	Current A	Voltage V	Kg weld metal/ kg electrodes	No. of electrodes/ kg weld metal	Kg weld metal/ hour arc time	Burn-off time/ electrode (sec.)
2,0	300	20-45	21	0,67	145	0,7	40
2,5	300	40-85	23	0,68	91	0,9	45
3,2	350	40-100	23	0,73	44	1,4	53

Classification:

AWS A5.4 E 316L-17
ISO 3581-A E 19 12 3 L R 11

Approvals:

CE
DNV
LR
TÜV

Note

Core wire:
P ≤ 0.020%
S ≤ 0.015%
N ≤ 0.080%

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