



Cromarod B316L

SMAW - (Stick) - MMA
Stainless Steel

Date: 2020-12-01
Revision: 7

Description:

Basic coated stainless steel electrode for type 316L steel grades. Produces weld metal with higher toughness at lower temperatures compared to rutile coated electrodes. The basic coating results in higher resistance to porosity due to improved gas shield, making the electrode highly suitable for on site welding. Cromarod B316L has an easy slag removal even in narrow joint preparations, reducing the post weld cleaning time.

Applications:

Offshore, pipeline, restrained joints.

Welding positions:



Coating type:

Basic

Welding current:

DC+

Ferrite content:

FN 5 (WRC 92)

Metal recovery:

110%

Redrying temperature:

350 °C, 2h

Chemical composition, wt. %

	C	Si	Mn	P	S	Cr	Ni
Min			0,8			17,0	11,0
Typical	0,03	0,35	1,0	0,02	0,01	18,5	12,0
Max	0,04	0,50	1,2	0,030	0,025	20,0	13,0

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

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 320 MPa	470 MPa
Tensile Strength, Rm:	≥ 510 MPa	575 MPa
Elongation, A5	≥ 30%	35%
Impact energy, CV:		-50 °C • 65 J -196 °C • 40 J lat exp 0.5 mm

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.)
2,5	300	50-80	24	0,69	86	0,83	43
3,2	350	75-125	25	0,69	43	1,24	59
4,0	350	100-165	26	0,69	28	1,94	60

Classification:

EN ISO 3581-A E 19 12 3 L B 42
AWS A5.4 E316L-15

Approvals:

CE

Note

For fixed pipe position PF/5G, electrode diameter 3,25 mm is the max recommended size.

Core wire:

P ≤ 0.020%

S ≤ 0.015%

N ≤ 0.080%

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