



Nexus 316L

19%Cr 12%Ni 3%Mo - Stainless Steel electrode for MMA welding

Rutile Stainless Steel Electrode for the joining low Carbon Molybdenum bearing Austenitic alloys and for cladding mild steel to provide a corrosion resistant surface. Producing butt and mitre finish fillet welds that are smooth and free of spatter.

International Standards

BS EN 1600:1997	AWS A5.4 - 06
E 19 12 3 LR 3 2	E316L-17

Typical All-Weld Metal Analysis (wt%)

C	Si	Mn	S	P	Cr	Ni	Mo	Ferrite
<0.03	0.8	0.7	0.012	0.015	18.5	12.0	2.7	7

Typical All-weld Metal Mechanical Properties

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact Strength +20°C
>400	>560	>35	>70

Welding Positions

Flat butt welds, flat fillet welds and horizontal vertical fillet welds

Materials

316, 316L

Packaging

Size mm	2.5 x 300	3.2 x 350	4.0 x 350
Pieces/Packet	133	73	48
Pieces/Carton	532	292	192
Kg/Packet	2.5	2.5	2.5
Packs/Carton	4	4	4
Kg/Carton	10	10	10

Operating Requirements

DC+ AC (70ocv min)	65 – 90 A	90 – 120 A	120 – 150 A
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Additional Information

CE Certified	Constructional products directive (CPD)
Certification	BS EN 10204:2004 Type 2.2
Material safety data sheet	MSDS 05
Re-dry	2 Hours @ 250°C if required
Related Nexus Products	MIG Nexus 316LSi TIG Nexus 316L