

Standards

TS EN ISO 3581-A	: E 19 12 3 L R 32
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AWS A5.4	: E316L-17

**Chemical Composition of
Weld Metal % (Typical)**

C	Si	Mn	Mo	Ni	Cr
0.03	0.8	0.9	2.6	11.5	19.0

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation (Lo=5do) (%)
min. 355	540-670	min. 47 J	min. 30

Typical Base Material Grades

- EN: X10CrNiMoNb 18 12, X2CrNiMo 18 14 3, X5CrNiMo 17 13 3, X2CrNiMo 17 13 2, X2CrNiMoN 17 12 2, X5CrNiMo 17 12 2, X5CrNiMoTi 17 12 2, X6CrNiMoNb 17 12 2, X2CrNiMoN 17 13 3.
- AISI: 316Cb, 316, 316L, 316Ti

Features and Applications

- Rutile-coated low-carbon electrode for use in tanks, pipes and equipments made of Cr-Ni-Mo low-carbon steels which are used in food, textile, chemical and paint industries
- Weld metal is resistant to acid, corrosion
- Serviceability at temperatures up to 400°C
- Requirement of Re-drying for min. 2 hours at the temperatures between 120°C and 200°C

Welding Positions

Current Type

D.C.(+) / A.C.

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101268	2.50 x 250	3/32 X 10"	50-90	1480
3010101273	3.20 x 350	1/8 X 14"	80-120	3470
3010101278	4.00 x 350	5/32 X 14"	110-160	5030

Approvals: TSE, CE, SEPRO