



## **M-90 E316L**

### **FEATURES**

- \*GOOD RESISTANCE TO CORROSION AND OXIDIZING ENVIRONMENTS
- \*GOOD HEAT RESISTANCE
- \*EASY TO REMOVE FLAG
- \*HIGH MOISTURE RESISTANCE (17TYPE)

### **APPLICATION**

- \*Rutile coated electrode for welding on stabilized corrosion resistant Cr-Ni-Mo steels.
- \*Smooth metal transfer with both AC and DC.
- \*Weld metal beads exhibit fine ripple formation.
- \*Focused and stable arc with low spatter loss.
- \*Easy slag release.
- \*Moisture resistant formula producing welds free from porosity.

### **CLASSIFICATION**

- \*A5.4/ ASME SFA5.4 E316L-16

### **CHEMICAL COMPOSITIONS**

C	Si	Mn	P	S	CR	Ni	MO
0.025	0.80	0.80	0.03	0.29	18.7	11.3	2.5

### **MECHANICAL PROPERTIES**

T.S	EL
N/mm2 (lbs/in 2 )	(%)
572 (83,100)	40.8

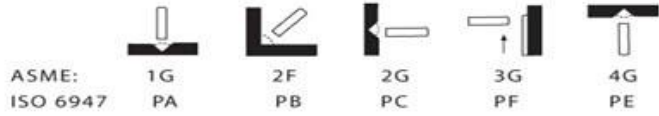
### **WELDING PARAMETERS**

DIAMETER (mm)	2.5	3.2
LENGTH (mm)	350	350
CURRENT (amps)	50-85	70-100

### **CURRENT**

- \*AC or DC +/-

# WELDING POSITIONS



**Current**

= +	~	(U <sub>o</sub> : 60V)
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