DURA MAX 316L-16 - DM316L-16 FLUX COATED STAINLESS STEEL ELECTRODE

Classification: AWS A5.4 / ASME SFA 5.4

Typical Application

For molybdenum bearing stainless steels with 1.5 to 3.0% Mo. Primarily used for resistance to pitting, many acids and general corrosion.
Maintenance quality smooth running molybdenum bearing 316L-16 electrode

Characteristics on Usage

1) Excellent all position capabilities.
2) Extra low carbon content to resist pitting.
3) Suitable for titanium and niobium stabilized versions of 316L stainless.

All Weld Chemical Composition (%)

C	Mn	Si	S	P	Cr	Ni	Cu	Mo	Fe
0.018	0.90	0.75	0.01	0.02	19.00	12.00	0.10	2.65	bal

Microstructure: Austenite with 7 - 9% ferrite. Typical ferrite number is 6.
Flux Color: White - Grey

Typical Mechanical Properties

Tensile Strength	Yield Strength	Elongation	Impact Energy	Hardness
80,000 PSi (550 MPa)	56,000 PSI (390 MPa)	42%	40J: -157°F (-105°C)	Brinell 209, Rockwell B96

Sizes available and recommended currents (DC +) or (AC)

Dia. (mm)	Amperage	Weldmetal/ Electrode	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition min / lb (kg)	Amperage Settings	Recovery Rate
5/64 (2.0mm)	30 ~ 50	.14 oz (4g)	114 (251)	47 (103)	40	100%
3/32 (2.5mm)	55 ~ 75	.3 oz (9g)	50 (109)	35 (76)	65	100%
1/8 (3.2mm)	75 ~ 110	.7 oz (20g)	22 (49)	21 (46)	95	100%
5/32 (4.0mm)	90 ~ 140	1 oz (29g)	15 (33)	18 (40)	120	100%

POLARITY: DCEP or AC
DCEP = DC, Electrode Positive (reverse polarity) has the most weld penetration.
AC: medium weld penetration (can be more spatter)
USE LESS AMPS ON THIN METAL; MORE AMPS ON THICK METALS
WELDING POSITIONS: Flat, Horizontal, Vertical-up and Overhead positions

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The above information is to be use as a guideline and is taken directly from the manufacturers Technical Data Sheet. If additional information is needed please contact us at 1-800-692-5930