euromarc
ELITE

ELECTRODE
Stainless Steel – E316L-16

747

GENERAL DESCRIPTION

Elite 747 is a extra low carbon, Rutile semi-basic Mo containing MMA electrode for the welding of austenitic stainless steels containing 16-20%Cr, 10-14%Ni and 2-3%Mo (AISI 316 & 316L).

- Excellent weldability stable arc
- Also suitable for the general welding of 300 series Stainless Steel
- Almost nil spatters
- Self-releasing slag
- Finely rippled bead surface
- Very easy arc striking and re-striking
- Low moisture absorption properties (LMA-Type)
- All positional (except vertical down) welding.
- Vacuum packed

WELDING POSITIONS

CLASSIFICATION

AS/NZS 4854 B-ES316L-16
ISO 3581-A : E 19 12 3 LR 32
AWS: A5.4 E316L-16

CHEMICAL COMPOSITION

Wt% -	Si	C	Mn	Cr	Ni	Mo	S	P
wire	0.90	0.23	0.70	18.80	12.00	2.50	0.012	0.025

TYPICAL MECHANICAL PROPERTIES

Typical as welded	
Tensile strength	610 MPa
Elongation A5(%)	40%
Charpy Impact Value (ISO-V J RT)	80J

DEPOSITION DATA – AC / DC (+)		
	2.5mm	**3.2mm**
Current (A)	50-80A	70-110A
Voltage (V)	Determined by arc current and electrode arc length.	

Welding parameters are a guide only as they are dependent on the machine used, material thickness and operator experience.
No data is to be construed as a recommendation for any welding condition or technique by Euromarc.

CONFORMANCE AND APPROVAL

CE
LR
TUV
DB

REBAKING

Re-baking is not necessary if the package is intact.
Redry electrodes at 300-350°C for 1-2 hrs, if necessary, before use.
Interpass temperature: <200ºC.

ELITE

ELECTRODE

Stainless Steel – E316L-16

747

STORAGE
Store open packets in a heated cabinet.

WARNING
Electric shock can kill. Arc rays can injure eyes. Welding fumes are hazardous to your health and may damage lungs and other organs. Use adequate ventilation. Arc rays and sparks can injure eyes and burn skin. Wear correct hand, head, eye and body protection. Read and understand the Safety Data Sheet for this product.

PACKAGING INFORMATION

Size	Weight	Length	Vacuumed Packed	Part Number / Order code
2.5mm	2kg	350mm	Yes	VE74725302
3.2mm	2kg	350mm	Yes	VE74732305