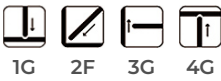


S-316.16N

Classification

- AWS** A5.4/ASME SFA-5.4 E316-16
- JIS** Z 3221 ES316-16
- EN** ISO 3581- A E 19 12 3 R
- KS** D7014 E316-16

Welding Positions



Features

- Good resistance to corrosion and oxidizing environments
- Good heat resistance
- Easy to remove slag
- Low spatter

Polarity

AC or DC+

Application Areas

- Stainless steel (18%Cr-12%Ni-2%Mo)

Redrying Conditions

350°C (662°F) X 1hr

Approvals

ABS	BV	DNV	KR
✓	✓	✓	✓

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S	Cu	Ni	Cr	Mo
0.03	0.77	0.9	0.030	0.019	0.02	12.3	18.7	2.5

Typical Mechanical Properties of All-Weld Metal

Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft · lbs)
572(83)	41	-20(0) -60(-75)	50(37) 42(31)

SAW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
2.0 (5/64)	300 (12)	25~55	20~50	PVC - Packet 2.5kg(5.5lbs), Carton 10kg (22lbs)
2.6 (3/32)	300 (12)	50~85	45~80	
3.2 (1/8)	350 (14)	70~115	65~110	
4.0 (5/32)	350 (14)	95~145	85~135	
5.0 (3/16)	350 (14)	135~180	-	

SMAW

GMAW

GTAW

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Metal-cored Wire

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