

VALIANT

VALIANTWELD-316L

AWS:A5.4:E316L-16 IS-5206 :E19.12.2 LR26

Valiantweld 316 Lisa stainless steel electrode depositing an extra low carbon 18 % Cr., 12 % Ni and 2.3 % Mo stainless steel weld metal. The weld metal has excellent resistance to intergranular corrosion even at elevated temperatures. Ideally suited for welding stainless steel of similar composition.

CHEMICAL COMPOSITION

C	Mn	Si	Cr	Ni	Mo
0.03	1.75	0.45	18.5	12.5	2.3

MECHANICAL PROPERTIES

UTS (Kg/mm ²)	EI (L = 4D)%
54.0	38.0

WELDING PARAMETERS

	Size (mm)	Current (Amp.)
AC/DC (-)	4.00 X 350	110-140
	3.15 X 350	80-100
	2.50 X 350	60-80

APPLICATION

Ideally suited for welding of hardenable steels, clad steels, C-Mo, Cr-mo steels where pre heat and post weld treatment are not feasible.

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