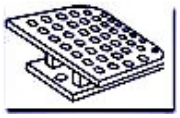
SHUBER E 616L



STAINLESS STEEL - CORROSION RESISTANCE

DESCRIPTION

STAINLESS STEEL ELECTRODE DEVELOPED FOR WELDING AUSTENITIC STAINLESS AND ACID RESISTANT STEELS SUCH AS AISI 316, 316L and 317. ALLOYED WITH 2.5% MOLYBDENUM INCREASING THE CORROSION RESISTANCE OF THE DEPOSIT TO "PITTING" ACTION OF CORROSIVE CHEMICALS. Extra-low carbon content in the weld deposit insures against intergranular carbide precipitation. Ideal for fabricating, cladding and repair of equipment in rayon & dye manufacturing plants, paper, textile, fertilizer, distillery and other chemical process industries.

SPECIAL FEATURES

- Excellent resistance to high concentrations of sulfuric, nitric, halogen acids & alkalis.
- Deposit is automatically synergized with passivators included in the slag. Forms super tough outer shell that even the most extreme corrosion can not break down.
- Can be deposited at lowest amperages to minimize warpage and distortion.

APPLICATION INSTRUCTIONS

Deposit stringer beads with as short an arc as possible. Avoid weaving to prevent slag inclusions. Use skip or stepback technique to avoid overheating and warpage. Remove slag between each pass.

TYPICAL WELD METAL ANALYSIS:

C	Cr	Mn	Ni	Mo
0.03% (max)	19.0%	0.80%	11.5%	2.50%

TENSILE STRENGTH: 63 kg/mm² (90,000 psi)

ELONGATION: 48%

RECOMMENDED CURRENT:
AC or DC +(Reverse Polarity)

DIAMETER	AMPS
2.4 mm (3/32")	40 - 70
3.2 mm (1/8")	80 - 110
4.0 mm (5/32")	110 - 150

Tip Colour: Yellow

DIN 8556