

CORE-BRIGHT 316L

Welds types 316, 316L and 318 steels. Contain 2-2.5% molybdenum to increase the corrosion resistance to pitting induced by sulfuric and sulfurous acids, sulphites, chloride, and cellulose solutions. Used extensively in the rayon, dye, and paper industries.

Specifications

Classifications	AWS A5.22 : E316LT0-3
Approvals	ASME SFA 5.22 AWS A5.22 : E316LT0-3 CERTIFIED BY C.W.B.- AWS A5.22

Approvals are based on factory location. Please contact ESAB for more information.

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	430 MPa	600 MPa	42 %

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Efficiency (%)	Deposition Type	TTW Dist.	Deposition Rate
1.2 mm	110 A	26 V	762 cm/min	86 %	Spray Transfer	19 mm	2.6 kg/h
1.2 mm	150 A	27 V	1016 cm/min	86 %	Spray Transfer	19 mm	3.67 kg/h
1.2 mm	180 A	27 V	1270 cm/min	87 %	Spray Transfer	19 mm	4.45 kg/h
2.4 mm	250 A	26 V	284 cm/min	85 %	Spray Transfer	25.4 mm	3.8 kg/h
2.4 mm	250 A	26 V	338 cm/min	89 %	Spray Transfer	38 mm	4.5 kg/h
2.4 mm	300 A	28 V	345 cm/min	85 %	Spray Transfer	25.4 mm	4.6 kg/h
2.4 mm	300 A	28 V	402 cm/min	89 %	Spray Transfer	38 mm	6.1 kg/h
2.4 mm	350 A	29 V	467 cm/min	88 %	Spray Transfer	25.4 mm	6.3 kg/h
2.4 mm	350 A	29 V	577 cm/min	87 %	Spray Transfer	38 mm	7.8 kg/h
2.4 mm	400 A	30 V	561 cm/min	85 %	Spray Transfer	25.4 mm	7.3 kg/h
2.4 mm	400 A	30 V	767 cm/min	87 %	Spray Transfer	38 mm	10.3 kg/h
2.4 mm	450 A	30 V	693 cm/min	85 %	Spray Transfer	25.4 mm	9.3 kg/h
2.4 mm	450 A	30 V	871 cm/min	87 %	Spray Transfer	38 mm	11.7 kg/h
2.0 mm	210 A	24 V	348 cm/min	86 %	Spray Transfer	19 mm	3.2 kg/h
2.0 mm	250 A	26 V	460 cm/min	87 %	Spray Transfer	19 mm	4.3 kg/h
2.0 mm	300 A	27 V	599 cm/min	85 %	Spray Transfer	19 mm	5.4 kg/h