



## STAINLESS STEEL WELDING ELECTRODES

# RASI E 316-16

### TECHNICAL SPECIFICATION SHEET



#### CHARACTERISTICS

RASI 316-16 is a titania mixed type stainless steel electrode of the Cr 19-Ni 12 group enriched with 2.5% Mo for enhanced resistance to corrosive media such as dilute sulphuric acid, acetic acid and chlorides. Offers welder - friendly features.

#### APPLICATIONS

In hot Sulphuric Acid, Acetic Acid and Chloride handling Equipments and dyeing vats using low Mo 19-9 stainless steels. For the welding of 19/12 Mo SS, represented by AISI types 316. 317; for welding of equipments on chemical industries, paper and pulp industry, paint and dye industries, etc.,

#### CLASSIFICATIONS

AWS/SFA 5.4 E 316-16  
IS : 5206 E 19.12.2 R 26

\*Extra Low Carbon Version is also available 316L-16 Carbon : 0.04 max  
IS : 5206 E 19.12.2 LR26, AWS A/SFA 5.4 : E 316L-16

storage - Store in warm and dry place. If damped re dry at 300°C for 1 hour.

\*All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

#### CHEMICAL COMPOSITION OF ALL WELD METAL

Carbon - 0.08%	Silicon - 0.9%
Manganese - 0.5 - 2.5%	Sulfur - 0.03%
Phosphorus - 0.03%	Cr - 17 - 20%
Ni - 11 - 14%	Mo - 2 - 3%

Note: Single Values shown above are maximum

#### MECHANICAL PROPERTIES OF ALL WELD METAL

UTS (MPa) - 530 Min.  
ELONGATION % - 30 Min.  
Ferrite No. - 4 - 8

#### WELDING CURRENT : AC, DC(±)

Ø 2.00 mm - 35 - 45 Amps  
Ø 2.50 mm - 50 - 75 Amps  
Ø 3.15 mm - 80 - 100 Amps  
Ø 4.00 mm - 110 - 140 Amps

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