

ESAB 316KCR



An extra low carbon stainless steel electrodes giving nil ferrite in deposited weldmetal



Classification AWS A 5.4: E 316L-16 (mod)

DESCRIPTION

ESAB 316KCR is a specially designed extra low carbon stainless steel electrode giving a ferrite free, fully austenitic weldmetal with better corrosion resistance to hydrochloric, nitric and sulphuric acids. The deposited weldmetal meets the corrosion test requirements of ASTM A262 Practice B, C and E. The arc and current carrying characteristics are excellent with a smooth and stable arc with very little spatter. The slag cover easily detaches and the final weldbead is smooth, shiny and finely rippled.

APPROVALS : SNAMPROGETTI (CR.UR.510), PDIL

WELDING CURRENT: DC +

TYPICAL APPLICATIONS

ESAB 316 KCR is especially designed for both welding and cladding of 316L UREA GRADE steels, used for Urea reactors, stainless steels used for pickling plates, chemical plants where better corrosion resistance is required for hydrochloric acid sulphuric acid etc.

TYPICAL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.025	Mo	0.025	UTS	550 N/mm ²
Mn	1.30	Si	0.35	YS	390 N/mm ²
Cr	18.00	S	0.015	EL (L=4d)	40%
Ni	15.00	P	0.018	Ferrite	NIL

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	40-80	80	400
3.15	350	60-90	65	325
4.00	350	90-140	40	200
5.00	350	130-175	30	150

PACKING: Electrodes are packed in heat sealed plastic cartons and five of these cartons are shrink wrapped in a cardboard box.