

SA 316L strip

CATEGORY	ESAW Electroslag	
TYPE	Stainless steel strip for cladding overlay applications.	
APPLICATIONS	Cladding tanks, vessels, tubes etc.	
PROPERTIES	Latest generation clean melting quality guarantees optimum metallurgical quality and attractive welder appeal. Combined with our high basic electro slag flux FL 830 ESHC excellent results are obtained in both deposition rate as minimum dilution rate due to the higher slag temperature compare to other electro slag fluxes.	
CLASSIFICATION	AWS	A 5.9: EQ 316L
	EN ISO	14343-A: S 19 12 3 L
	DIN: W.Nr.	1.4430

SUITABLE FOR Cladding applications where a 18/8/2 (AISI 316) CrNiMo layer is required to offer good resistance against general corrosion, particularly to corrosion in acid and chlorinated environments.

WELDING POSITIONS:



ALL WELD DEPOSIT ANALYSIS

C	Mn	Si	Cr	Ni	Mo	P	S
<0.025	<2.0	<0.9	16-18	10-14	2.0-3.0	<0.045	<0.030

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				+20°C	-40°C	-196°C	
AW	440	620	37	120		55	

AW: as welded

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters (ES)		kg / coil	Packing
	Voltage (V)	Current (A)		internal coil size (mm)
30 x 0,5	23-25	500-650	25-50	500
60 x 0,5	23-25	1000-1300	25-50	500
90 x 0,5	23-26	1400-1900	50-100	500

REDRYING TEMPERATURE not required