

## 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 <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	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

Welding Parameters (ES)			Packing	
D (mm)	Voltage (V)	Current (A)	kg / coil	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