daikowelding.com

DATA SHEET N. S032

G-TECH 316LR

SMAW electrode

Description / Alloy type: Rutile coated low carbon electrode for 316L Mo bearing austenitic stainless steels

Specifications:

AWS A5.4	**EN ISO 3581-A**
E316L-17	E 19 12 3 LR 12

Approvals: TÜV; CE.

Applications: These consumables are used for Mo bearing austenitic stainless steels with 1.5 ÷ 3 Mo.
316 steels are used for their good resistance to pitting, many acids and general corrosion.

Materials to be welded: **ASTM**: 316L; 316, 316LN; CF3M; CF8M;
EN & DIN: 1.4404/1.4401; 1.4436; 1.4406/1.4429; 1.4408; 1.4437.

Composition: (weight %)

%	C	Mn	Si	S	P	Cr	Ni	Mo*	Cu	FN
Min	-	0.5	-	-	-	17	11	2.0	-	3
Max	0.04	2.0	0.9	0.025	0.03	20	13	3.0	0.5	10
Typ	0.03	0.6	0.8	0.010	0.02	18	12	2.7	0.1	6

(*) EN require Mo 2.5÷3.0%

Welding positions: 

DC+

All-weld properties:

As welded	Min	Typical
Tensile strength [MPa]	520	560
0.2% proof stress [MPa]	320	460
Elongation 5d [%]	25	35
Impact Energy +20°C [J]	-	60
Impact Energy -60°C [J]	-	>47

Current: d. 2.5mm **50-75A**; d. 3.2mm **75-110A**; d. 4.0mm **110-150A**;
Redrying: 200-300°C / 1-2h, 3 times max.

Other products:
G-Tech 316LB SMAW basic electrode (AWS A5.4 E316L-15)
G-Tech 316L SMAW rutile electrode (AWS A5.4 E316L-16)
DAIKO GMAW, GTAW & SAW wire (AWS A5.9 ER316L / ER316LSi)
DAIKO FCAW wire (AWS A5.22 E316LT0-1/4 / E316LT1-1/4)
DAIKO ESW strip (AWS A5.9 ~EQ316L)

01/2024

REGISTERED OFFICE
DAIKO S.R.L
Viale G. G. Felissent 84/D, 31100 Treviso, Italia
REA 416562 VAT and T.C. IT04907220265

DAIKO S.R.L. Headquarter
Via Toscana, 3A-3B - 20056
Grezzago (MILANO) - Italy
Ph.+39 02 9090477

NORD-EST BRANCH OFFICE
Via Aquileia, 13-15 - 31048
S. Biagio di Callalta (TREVISO) - Italy
Ph. +39 0422 796367