

## AI-0226

### Specifications

**AS/NZS** 1553.3 : E316L-16

**AWS/ASME** A5.4 : E 316L-16

### Description and Applications

Austenitic rutile coated electrode for welding stainless steels containing 16-21% Cr, 10-15% Ni, 2-3% Mo (Generally type 316L) when easy welding and fine bead appearance are required. Deposit has excellent resistance to most corrosive media. Resists intergranular corrosion up to 400°C.

### Typical Weldmetal Analysis

C	Mn	Cr	Fe	Ni	Si	Mo
0.03	0.8	18.8	Bal	11.5	0.8	2.7

### Mechanical Properties of Weldmetal

	As Welded
Tensile Strength	600MPa
Yield Strength (0.2%)	460Mpa
Elongation	36% (5d)
Charpy	70J at 20°C

### Welding Parameters

Diameter (mm)	Current type	Amps
1.6	DC/AC	25-40
2.0	DC/AC	40-60
2.5	DC /AC	50-90
3.2	DC /AC	80-120
4.0	DC /AC	110-160

Also available as TIG: **AI-0226T**, MIG wire: **AI-1716**, Flux cored tubular wire: **AI-1516** and Arc spray wire: **AI-1844**

### Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position, (2G) Horizontal vertical position, (4G) Overhead position, (3G, 3F, 5G up) Vertical Position Up

### Disclaimer

All figures in this datasheet should be considered indicative only. No guarantee is made as to their accuracy.

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