

## SK 316L-O

DIN 8555 : MF 9-GF-150-C  
ASME IIC SFA 5.22 : E 316L-T3

### DESCRIPTION

1

Self shielded cored wire with slag depositing a 19% Chromium – 12% Nickel – 2.5% Molybdenum low Carbon composition.

### SUITABLE FOR

2

Cladding of stainless steels containing 16-21% Cr, 10-15% Ni and 0-3% Mo on un or low alloyed carbon steels.

### TYPICAL CHEMICAL ANALYSIS (WEIGHT %)

3

|          | C    | Mn  | Si  | Cr    | Ni    | Mo  | Fe   |
|----------|------|-----|-----|-------|-------|-----|------|
| All Weld | 0.03 | 0.8 | 0.9 | 19.50 | 12.50 | 2.7 | Bal. |

### TYPICAL MECHANICAL PROPERTIES

4

Hardness as welded

NA

### GENERAL CHARACTERISTICS

5

- Microstructure: Austenite +/- 10% ferrite
- Machinability: Good
- Oxy-acetylene cutting: Cannot be flame cut
- Deposit thickness: No restriction
- Flux cored



### WELDING PARAMETERS & ECONOMICAL DATA

6

| Diameter [mm] | Current [A] | Voltage [V] | Stick-Out | Article code | Packaging   | Availability                     |
|---------------|-------------|-------------|-----------|--------------|-------------|----------------------------------|
| 1,6           | 180-220     | 26-29       | 35-40     | 29466        | Spool 15 Kg | On request with minimal quantity |

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