

# GRINOX 16L

## IDENTIFICATION : GRINOX-16L E316L-16

**CLASSIFICATION:** AWS/SFA 5.4: E316L-16, IS 5206: E19.12.2 LR16

### CHARACTERISTICS:

A medium heavy coated rutile type stainless steel electrode depositing low carbon 18/13/ 2.5 Mo austenitic stainless steel weld metal. Deposited weld metal has very high resistance to hot cracking, chemical corrosion upto 800°C and stress corrosion cracking. Molybdenum imparts resistance to corrosion of reducing nature. The deposited weld metal is of radiographic quality.

### TYPICAL APPLICATIONS

- Suitable for welding stainless steels extra low carbon or stabilised by Titanium or Niobium such as AISI grades 316L, 317L and 318, S.S. clad plates, chemical plants, paint and dye industries.
- For welding stainless steel of 18/8/3 type as represented by AISI grades 316L, 317L & 318.

**Ferrite content in the weld metal:** 3 to 9 FN

**REDRYING:** 250°C/2 hrs. Max 5 cycles, 10 hr. total.

### WELD METAL ANALYSIS (RANGE) %

| C             | Mn            | Si          | S           | P           |
|---------------|---------------|-------------|-------------|-------------|
| 0.04<br>max   | 0.50-<br>2.50 | 0.9<br>max  | 0.03<br>max | 0.04<br>max |
| Cr            | Ni            | Mo          | Cu          |             |
| 17.0-<br>20.0 | 11.0-<br>14.0 | 2.0-<br>3.0 | 0.75<br>max |             |

### MECHANICAL PROPERTIES (RANGE)

| UTS<br>(MPa) | YS<br>(MPa) | ELN<br>(%)<br>(L=4D) | CVN<br>Impact |        |
|--------------|-------------|----------------------|---------------|--------|
|              |             |                      | Temp          | Joules |
| 490<br>min   | 400-<br>500 | 30-40                | 27°C          | 70-120 |

### RECOMMENDED CURRENT AND PACKING DATA:

| SIZE<br>(mm) | LENGTH<br>(mm) | AMPS<br>AC/DC(+) | PACKING/BOX<br>(KG) |
|--------------|----------------|------------------|---------------------|
| 2.50         | 350            | 60-80            | 2 × 5 = 10          |
| 3.15         | 350            | 80-110           | 2 × 5 = 10          |
| 4.00         | 350            | 110-140          | 2 × 5 = 10          |
| 5.00         | 350            | 140-180          | 2 × 5 = 10          |

## Manufactured by: GEE LIMITED

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Thane, Maharashtra, India.  
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