



RUTILE TYPE ELECTRODE FOR 18cr - Ni11 - Mo 2.5 STAINLESS STEEL

TECHNICAL DATA

Alloy Type :
Typical 316 steels
Tensile Strength :
620 N/mm ²
Elongation :
30 - 40 %
Machinability :
Good

RECOMMENDED CURRENT RANGE

ELECTRODES	
SIZE (MM)	AMPS
2.50	50-70
3.15	85-100
4.00	115-135
5.00	140-180

FEATURES :

Complies with AWS specifications and is for welding austenitic 316 stainless steels. It gives smooth and defect-free weld metal of radiographic quality. Extremely quiet and stable arc with easy striking.

APPLICATIONS :

CARVER 9316 is ideal for welding type 316, 316L, and 317 stainless steels in applications where low friction overlay with increased corrosion resistance are important. For repair of cracks in heavy machinery parts, earth moving equipments. Chemical vessels and plants, breweries and food equipments.

PROCEDURE :

Clean all areas to be welded and keep interpass temperatures as low as possible while welding on 300 series stainless steels. On AC/DC use reverse polarity, heavier sections should be beveled 60°. Maintain short arc and deposit stringer beads. avoid weaving. Deposit a number of light beads.



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