

OK Tigrod 316L

Bare corrosion resisting chromium-nickel-molybdenum welding rods for welding of austenitic stainless alloys of 18% Cr - 8% Ni and 18% Cr - 10% Ni - 3% Mo-types. OK Tigrod 316L has a good general corrosion resistance, particularly against corrosion in acid and chlorinated environments. The alloy has a low carbon content which makes it particularly recommended where there is a risk of intergranular corrosion. The alloy is widely used in the chemical and food processing industries as well as in shipbuilding and various types of architectural structures.

Classifications Wire Electrode	SFA/AWS A5.9 : ER316L EN ISO 14343-A : W 19 12 3 L Werkstoffnummer : ~1.4430
Approvals	ABS ER 316L BV 316L BT CE EN 13479 CWB ER316L DNV-GL VL 316 L (I1) NAKS/HAKC 1.6 - 3.2 mm VdTUV 04270

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Austenitic (with approx. 10 % ferrite) 19% Cr - 12% Ni - 3% Mo - Low C
Shielding Gas	I1 (EN ISO 14175)

Typical Charpy V-Notch Properties

Testing Temperature	Impact Value
20 °C (68 °F)	175 J (129 ft-lb)
-60 °C (-76 °F)	130 J (96 ft-lb)
-110 °C (-166 °F)	120 J (88.5 ft-lb)
-196 °C (-321 °F)	75 J (55 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.01	1.8	0.4	0.01	0.02	12	19	2.6	0.1

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	N	FN WRC-92
0.01	1.7	0.4	12.0	18.2	2.6	0.04	7