



ELECTRODES FOR WELDING STAINLESS AND HEAT-RESISTING STEELS

GEMINI 316 L

GEMINI 316 L is a rutile high-alloy extra low carbon austenitic electrode for welding corrosion-resistant CrNiMo-steels resistant to atmospheric corrosion. Resistant to grain disintegration of operating temperatures up to 350 °C. Very smooth weld with clean weld edge, low spatter loss and easy slag removal. For welding AISI/ASTM 316,316L,316LN,316H,316Ti

Typical All-Weld Metal Properties			
Composition (%)		Mechanical	
C	0.02	Yield strength	482 N/mm ²
Mn	0.80	Tensile strength	550 N/mm ²
Si	0.60	Elongation	40 %
Ni	12.12		
Cr	18.00		
Mo	2.20		

Typical welding current

AC or DC+					
Ø/L (mm)	2.0/300	2.6/300	3.2/350	4.0/350	5.0/350
Current min/max (A)	30/50	50/75	75/110	110/150	140/190

International Standard	Printing	Welding Positions
AWS/ASME SF-A5.4 E316L-16	G-316L/E316L-16	Flat, horizontal, vertical-up and overhead