

GEMINI 316 L

AWS/SFA5.4 E 316L-16

Typical Applications And Characteristics

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 stress	490 N/mm ²
Mn	0.70	Tensile strength	550 N/mm ²
Si	0.60	Elongation	30 %
Ni	12.12		
Cr	18.00		
Mo	2.20		

AC or DC±					
∅/L (mm)	2.0X300	2.6X300	3.2X350	4.0X350	5.0X350
Current min/max (A)	30-50	50-75	75-110	110-150	140-190

Typical welding current			
Approval	Color	End	Silver
LR	Coding	Side	Red
	Printing	G-316L/E 316L-16	
	Welding Positions	Flat, horizontal, vertical-up and overhead	