

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.

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| Classifications Wire Electrode: | Werkstoffnummer : ~1.4430, SFA/AWS A5.9:ER316L, EN ISO 14343-A:W 19 12 3 L |
| Approvals: | CE EN 13479, ABS ER 316L, NAKS/HAKC 2.0MM-3.2MM, BV 316L BT, CWB ER316L, DNV 316L (-60 °C), VdTÜV 04270 |

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

| Typical Tensile Properties | | | |
|----------------------------|------------------|------------------|------------|
| Condition | Yield Strength | Tensile Strength | Elongation |
| As welded | 470 MPa (68 ksi) | 600 MPa (87 ksi) | 32 % |

| Typical Charpy V-Notch Properties | | |
|-----------------------------------|---------------------|--------------------|
| Condition | Testing Temperature | Impact Value |
| As welded | 20 °C (68 °F) | 175 J (129 ft-lb) |
| As welded | -60 °C (-76 °F) | 130 J (96 ft-lb) |
| As welded | -110 °C (-166 °F) | 120 J (88.5 ft-lb) |
| As welded | -196 °C (-321 °F) | 75 J (55 ft-lb) |

| Typical Wire Composition % | | | | | | | | |
|----------------------------|-----|-----|------|------|-----|------|------|-----------|
| C | Mn | Si | Ni | Cr | Mo | Cu | N | FN WRC-92 |
| 0.01 | 1.7 | 0.4 | 12.0 | 18.2 | 2.6 | 0.10 | 0.04 | 7 |