



Product Data Sheet
NSS-316L / NSW-316L
AWS E316L-16

DESCRIPTION

NSS-316L is a lime-titania type stainless steel electrode which gives an extra low carbon and virtually free from spatter.

Because of extra low carbon content especially, the deposited metal has more excellent resistance to the intercrystalline corrosion than that of ordinary 316 type.

Due to excellent properties at high temperature, it is widely used in various chemical industries. Peeling-off of the slag is very good.

APPLICATIONS

Welding of AISI316L.

INSTRUCTIONS FOR WELDING

Clean off dust or oil from the welding area in order to prevent from decreasing the corrosion resistance caused by interblending carbon to the deposited metal.

Typical Chemical Composition of Weld Metal (%):

C	Si	Mn	Cr	Ni	Mo
0.034	0.38	1.68	19.12	12.25	2.27

Typical Mechanical Properties of Weld Metal:

Tensile Strength N/mm2 (Ksi)	Elongation (%)
567 (82)	45

Size and Recommended Current Range (AC or DC +):

Diameter (mm)	1.6	2.0	2.5	3.2	4.0	5.0	
Length (mm)	255	255	300	350	350	350	
Ampere	Flat	20-50	20-50	50-80	70-110	100-150	130-180
	V&OH	15-45	15-45	45-75	65-105	95-140	-

Welding Positions:

FLAT, FILLET, VERTICAL UP, HORIZONTAL, OVERHEAD

APPROVALS: ABS

Packing:

EXPORT (1.6-2.5mm): 16 Kg corrugated box, with 4 units of 4 Kg plastic container.

EXPORT (3.2-5.0mm): 20 Kg corrugated box, with 4 units of 5 Kg plastic container.

LOCAL: 5Kg Special Paper Box with shrink wrapped plastic

Special requests on packing are accepted.