



Stainless Steel Stick Electrodes



Code & Specification

ASME SFA/AWS A5.4 E316L-16

Description

BLUME® E316L-16 is a stainless steel stick electrode. Flux coating provides a smooth arc transfer for all welding positions. Molybdenum grade for increased corrosion resistance. Delivers exceptional puddle control, a smooth arc, and excellent slag release.

Applications

BLUME® E316L-16 is used to weld type 316 and 316L. Used for molybdenum bearing austenitic stainless steels.

Mechanical Properties

	As-welded
Yield Point, MPa	425 - 450
Tensile Strength, MPa	560 - 585
Elongation, %(L=4d)	40 - 54

Undiluted Weld Metal Analysis (wt%)

C	Mn	Si	S	P
0.03 - 0.04	0.7 - 0.9	0.3 - 0.4	≤ 0.02	≤ 0.02
Ni	Cr	Mo		
11.5 - 13.0	18.0 - 19.0	2.2 - 2.4		

Packaging

∅ x L	Wt./Carton	Carton/Box	Net wt./Box
2.5mm x 350mm (3/32" x 14")	2.5 kgs (5.5 lbs)	8	20 kgs (44 lbs)
3.2mm x 350mm (1/8" x 14")	2.5 kgs (5.5 lbs)	8	20 kgs (44 lbs)
4.0mm x 350mm (5/32" x 14")	2.5 kgs (5.5 lbs)	8	20 kgs (44 lbs)

Suggested Welding Parameters

∅ x L	AC	DC±
2.5mm x 350mm (3/32" x 14")	40 - 70	40 - 70
3.2mm x 350mm (1/8" x 14")	60 - 100	60 - 100
4.0mm x 350mm (5/32" x 14")	90 - 140	90 - 140

Approvals



Blumenotics Pvt. Limited

An ISO 9001:2015 Company

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