

# RIMCONOX 316L

Stick Welding Electrode for Stainless Steel  
(Low C, 18% Cr, 12% Ni-Mo)

### APPLICATIONS & CHARACTERISTICS

RIMCONOX 316L is lime titania coated electrode for welding base metal 18% Cr-12 % Ni-Mo stainless steel (Low carbon). Excellent corrosion resistance against sulphuric acid, phosphoric and acetic acids.

### NOTE ON USAGE

- Redry the electrodes at 250 ~ 350°C for 30~60 minutes prior to use.
- Use proper current and keep the arc as short as possible.
- Suitable for flat and horizontal fillet welding.

### WELDING POSITIONS

PA, PB, PF, PC, PE

### TYPICAL CHEMICAL COMPOSITION OR ALL WELD METAL (%):

C	Mn	Si	P	S	Cr	Ni	Mo	Cu
0.030	1.08	0.72	0.028	0.013	18.40	12.50	2.50	0.3

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL

YS N/mm <sup>2</sup>	TS N/mm <sup>2</sup>	EL%
440	570	43

### ELECTRODE SIZES AND RECOMMENDED CURRENT RANGE POLARITY : AC OR DC +

Dia (mm)	2.6	3.2	4.0
Length (mm)	350	350	350
Amps.	50~80	80~110	120~150

### STANDARD PACKAGING :

2.6 mm Dia }  
3.2 mm Dia } 5kg / PKT  
4.0 mm Dia }



AWS A5.4-06 E316L-16  
EN 1600 : 1997 : E19 12 3 LR 12  
JIS Z 3221 : ES 316L-16



# RIMCODUR 350

For Hardfacing

DIN 8555 : E1- UM-350

### APPLICATIONS & CHARACTERISTICS

RIMCODUR 350 is a low hydrogen type electrode for crack and wear resistant surfacing. Suitable for hardfacing of fans, upper rollers, shafts and sprockets. Suitable for intermetallic abrasion and moderate impact abrasion. The deposit is still machinable with tungsten carbide tools.

### NOTE ON USAGE

- Redry the electrodes at 300 ~ 400°C for 1~2 hrs prior to use.
- Hold the electrode as vertically as possible with a short arc.

### WELDING POSITIONS

PA, PB

### TYPICAL CHEMICAL COMPOSITION OR ALL WELD METAL (%):

C	Si	Mn	P	S	Ni	Cr	Mo	W
0.36	0.65	0.74	0.014	0.011	0.02	2.00	0.01	0.01

Hardness of the pure weld deposit approx 36 HRC (350 HV)

### ELECTRODE SIZES AND RECOMMENDED CURRENT RANGE POLARITY : AC OR DC +

Dia (mm)	3.2	4.0	5.0
Length (mm)	350	400	400
Amps.	90~130	140~180	190~240

### STANDARD PACKAGING :

3.2 mm Dia }  
4.0 mm Dia } 5kg / PKT  
5.0 mm Dia }

