Standards:

EN ISO 3581-A: E 19 12 3 R 12
EN 1600: E 19 12 3 R 12
AWS A 5.4: E 316 H-16

capilla® 316 H

Product description:

Rutile-basic coated stick electrode suitable for fusion welding of heat resistant stainless Cr-Ni-Mo-steel grades.
Due to elevated Si- and Cr-contents the weld metal has better scaling resistance in comparison to Capilla 316 L.

Applications:

Suitable for welding steel grades like:

1.4401, 1.4404, 1.4406, 1.4408,
1.4420, 1.4435, 1.4436, 1.4571,
1.4573, 1.4580, 1.4581, 1.4583.

Typical weld metal composition:

[wt. - %]

	C	Si	Cr	Ni	Mo	Fe
Min.			**18**	**11**	**2,5**	
Max.	**0,03**	**1,0**	**20**	**13**	**3**	**Bal.**

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m:	550	[MPa]
Yield strength $R_{p0,2}$:	320	[MPa]
Yield strength $R_{p1,0}$:	-	[MPa]
Elongation (L=5d):	35	[%]
Impact strength (ISO-V):	70	[J]

Positions: all except PG

Redrying: 320°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]
2,0	300	40 – 60
2,5	300	60 – 90
3,25	350	80 – 110
4,0	350	100 – 150
5,0	450	150 – 200

Polarity =(+)~

also available:
find in table of content

Capilla 316 KB
Capilla 316 L
Capilla 316 LF
Capilla 316 LR
Capilla 316 MAG
Capilla 316 WIG
Capilla G 316 L RM (tubular wire)
Capicoat 316 H