

Standards:

EN ISO 3581-A: E 19 12 3 LR 12
 EN 1600: E 19 12 3 LR 12
 AWS A 5.4: E 316 L-16
 Mat.-No.: 1.4430

capilla® 316 LF**Product description:**

Rutile-basic coated stick electrode for welding of austenitic stainless Cr-Ni-Mo steels with extra low carbon content;
 Service temperatures up to 400°C;

Suitable for welding in vertical down (VD) position

Applications:

Suitable for materials as:
 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	Cr	Ni	Mo	Fe
Min.		18	11	2,5	
Max.	0,03	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

Redrying: 300°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]	Polarity
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	

also available:
 find in table of content

Capilla 316 H
 Capilla 316 KB
 Capilla 316 L
 Capilla 316 LR

Capilla 316 L MAG
 Capilla 316 L WIG
 Capilla G 316 L RM (tubular wire)