

MMA Electrodes Stainless and Heat resistant steels

SUPRANOX 316LP is a thin basic-rutile coated MMA electrode for welding austenitic stainless Cr-Ni-Mo steels/ cast steels, with an extra low carbon content. For operating temperatures <400 °C. SUPRANOX 316LP is a good compromise between ease of use when positional welding and bead finish. Particularly recommended for welding pipe work.

Classification	
EN	1600: E 19 12 3 L R 1 2
AWS	A5.4: E 316L-16

Approvals	Grade
ABS	316L
BV	UP
DNV	316L
LRS	316L

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Ferrite
≤ 0.03	0.7	0.6	≤ 0.025	≤ 0.02	18.2	11.3	2.6	4-8

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				20 °C
As Welded	≥ 320	≥ 510	≥ 30	≥ 50

Materials

1.4401 (X4CrNiMo17-12-2), 1.4435 (X2CrNiMo18-14-3)

1.4571 (X6CrNiMoTi17-12-2), 1.4583 (X10CrNiMoNb18-12)

AISI 316L

Storage

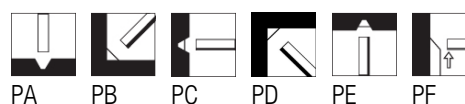
Keep dry and avoid condensation.

Re-drying not generally required

If necessary: 300-350 °C for 2 hours, 5 times max

Current condition and welding position

AC; DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	CBOX		DRYF	
				PC	Code	PC	Code
2.0	300	40-55	11.1	320	●	36	●
2.5	300	60-80	17.0	215	●	30	●
3.2	350	80-110	33.2	135	●	24	●
4.0	350	100-150	53.4	75	●	18	●