

Arcaloy 316L-17 PLUS

Arcaloy 316L-17 Plus electrodes have a heavy coating and produce a concave bead with minimal ripple. The slag is virtually self-cleaning. Molybdenum increases the resistance to pitting corrosion caused by corrosive media such as sulfuric and sulfurous acids, sulphites, chlorides and cellulose solutions. Ideal for welding Types 316 & 316L stainless steels when bead appearance is important.

Approvals	ASME IX F No. 5 ASME II SFA A5.4 : E316-17/E316L-17 AWS A5.4 : E316-17/E316L-17 CWB : CSA W48 E316L-17
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Typical Tensile Properties		
Yield Strength	Tensile Strength	Elongation
441 MPa (64 ksi)	572 MPa (83 ksi)	(in 2") 45 %

Typical Weld Metal Analysis %						
C	Mn	Si	Ni	Cr	Mo	Cu
0.02	0.6	0.6	12	19	2.5	0.1

Recommended Welding Parameters			
Wire Diameter	Flat Amps	Vertical Amps	Overhead Amps
2.0 mm (5/64 in.)	30-50 A	25-35 A	30-40 A
2.4 mm (3/32 in.)	60-85 A	40-60 A	40-60 A
3.2 mm (1/8 in.)	90-120 A	70-80 A	60-85 A
4.0 mm (5/32 in.)	140-165 A	80-90 A	95-120 A
4.8 mm (3/16 in.)	180-210 A	100-115 A	125-150 A
6.4 mm (1/4 in.)	205-290 A		
1.6 mm (1/16 in.)	20-35 A	15-25 A	20-30 A