

## CLASSIFICATION

EN 1600 : E 19 12 3 LR 12      Werkstoff-Nr : 1.4404 / 1.4430  
AWS A5.4 : E316L-16

## GENERAL DESCRIPTION

LSN-316 L is a low carbon rutile coated electrode. It gives a filler metal of the Cr-Ni-Mo type. Excellent quality smooth weld beads are highly resistant to acids and to intergranular corrosion at operating temperatures up to 350°C. It gives a stable arc and the slag is easy to remove.

## APPROVALS

CE, GOST, SEPRO, TSE

ABS	BV	DNV	GL	RINA
E316L-16	316L	NV 316L	4404	316L

## CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Si	Mn	Cr	Ni	Mo
0.03	0.70	0.80	17.00	11.00	2.90

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Yield Strength	: 490 N/mm <sup>2</sup>
Tensile Strength	: 600 N/mm <sup>2</sup>
Elongation (L=5d)	: 35 %
Impact (ISO-V)	: 60 J ( + 20°C)

## APPLICATIONS AND MATERIALS TO BE WELDED

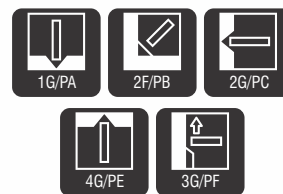
LSN-316 L can be used in the welding of pipes, tanks and vessels that are used in chemical, paint and paper industries. Cr-Ni-Mo steels, steel cast parts and pipes that are used for acid, gas and vapor transmission can also be welded with this electrode. LSN-316 L can also be used in the build up welding of leakproof surfaces.

	EN 10088-1/-2	EN 10213-4	W. Nr
<b>Extra Low Carbon Stainless Steels (C &lt; %0.03)</b>	X2 CrNiMo 17 12 2	–	1.4404
	X2 CrNiMo 18 14 3	–	1.4435
	X2 CrNiMoN 17 11 2	–	1.4406
	X2 CrNiMoN 17 13 3	–	1.4429
<b>Medium Carbon Stainless Steels (C &gt; %0.03)</b>	X4 CrNiMo 17 12 2	–	1.4401
	X4 CrNiMo 17 13 3	–	1.4436
	–	G-X5 CrNiMo 19 11	1.4408
<b>Stabilized Stainless Steels (Nb/Ti)</b>	X6 CrNiMoTi 17 12 2	–	1.4571
	X6 CrNiMoNb 17 12 2	–	1.4580
	X6 CrNiNb 18 10	–	1.4550
	–	G-X5 CrNiNb 19 10	1.4552

## WELDING PARAMETERS / PACKING AND DIAMETER INFORMATIONS / WELDING POSITIONS

Current Type and Polarity : AC min 50 V ; DC (+)

Diameter [ mm ]	Length [ mm ]	Current [ A ]	Electrode Weight [ g/100 pcs ]	Box Weight [ kg ] Quantity [ pcs/box ]	Export Box Box Weight [ kg ]
2.00	250	40 - 60	930	1.6 / 175	1.5
2.50	250	50 - 80	1620	1.6 / 100	1.5
3.25	300	80 - 120	2940	1.9 / 65	2.0
4.00	350	100 - 145	4920	2.0 / 40	2.5



**Liability** : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance.  
**Fumes** : Consult information on Welding Safety Sheet, available upon request.

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