

OK Tigrod 316L

Bare corrosion resisting chromium-nickel-molybdenum welding rods for welding of austenitic stainless alloys of 18% Cr - 8% Ni and 18% Cr - 10% Ni - 3% Mo-types. OK Tigrod 316L has a good general corrosion resistance, particularly against corrosion in acid and chlorinated environments. The alloy has a low carbon content which makes it particularly recommended where there is a risk of intergranular corrosion. The alloy is widely used in the chemical and food processing industries as well as in shipbuilding and various types of architectural structures.

Classifications Wire Electrode:	Werkstoffnummer : ~1.4430, SFA/AWS A5.9:ER316L, EN ISO 14343-A:W 19 12 3 L
Approvals:	CE EN 13479, ABS ER 316L, NAKS/HAKC 2.0MM-3.2MM, BV 316L BT, CWB ER316L, DNV 316L (-60 °C), VdTÜV 04270

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type:	Austenitic (with approx. 10 % ferrite) 19% Cr - 12% Ni - 3% Mo - Low C
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As welded	470 MPa	600 MPa	32 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As welded	20 °C	175 J
As welded	-60 °C	130 J
As welded	-110 °C	120 J
As welded	-196 °C	75 J

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu	N	FN WRC-92
0.01	1.7	0.4	12.0	18.2	2.6	0.10	0.04	7