

Shield-Bright 316L X-tra

Shield-Bright 316L X-tra was developed for the welding Type 316L stainless steel and also can be used for the other stainless steels including Types 316 and 304L. In a few cases, e.g. nitric acid service, Shield-Bright 316L X-tra should not be used to weld 304L. It was designed specifically for applications where the service environment can produce pitting corrosion. Shield-Bright 316L X-tra was developed for welding in the flat position and for horizontal fillet welds with flat to concave beads with excellent slag removal.

Classifications Weld Metal:	SFA/AWS A5.22:E316LT0-1, SFA/AWS A5.22:E316LT0-4, JIS Z 3323:TS316L-FB0 - KR, KS D 3612:YF 316LC - KR, EN ISO 17633-A:T 19 12 3 L R C1 3, EN ISO 17633-A:T 19 12 3 L R M21 3
Approvals:	CE EN 13479, ABS E316LT0-1 (C1), CWB E316LT0-1 (C1), CWB E316LT0-4 (M21), DNV 316L (C1), KR RW316LG (C1), LR 316L S (C1), VdTÜV 06612

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

Welding Current:	DC+
Alloy Type:	Austenitic 316L

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
C1 shielding gas AWS			
As welded	450 MPa	580 MPa	36 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
C1 shielding gas AWS		
As welded	-110 °C	38 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo
C1 shielding gas					
0.030	1.30	0.60	12.0	18.5	2.7

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	150-250 A	25-32 V	8.0-16.0 m/min	2.5-7.0 kg/h
1.6 mm	200-350 A	26-34 V	4.0-11.0 m/min	3.0-7.5 kg/h