



Unibraze 316L-16

Specifications: AWS A5.4/ASME SFA 5.4 Class E316L-16 UNS W31613

Description: Unibraze 316L-16 is a low carbon AC-DC titania coated stainless steel welding electrode. The low carbon content prevents intergranular corrosion. Unibraze 316L-16 is suitable for welding critical chemical vessels that require low temperature impact properties, such as liquid natural gas tanks. It also has good strength at high temperatures where no post weld heat treatment is required.

Typical Chemistry

<u>C</u>	<u>Cr</u>	<u>Ni</u>	<u>Mn</u>	<u>Si</u>	<u>P</u>	<u>S</u>	<u>Cu</u>	<u>Mo</u>
.04 max	17.0 -20.0	11.0 -14.0	.5 - 2.5	1.0 max	.04 max	.03 max	.75 max	2.0 - 3.0

Ferrite Content 5-12 WRC 1992

Typical Mechanical Properties

Tensile Strength	81,300 psi (560 MPa)
Yield Strength	58,000 psi (400 MPa)
Elongation	41%

Recommended Parameters (AC or DC+)

Diameter	3/32"	1/8"	5/32"	3/16"
F/H-fillet	50-85 amps	80-120 amps	100-150 amps	140-200 amps
V-up/OH	45-85 amps	70-110 amps	90-135 amps	100-130 amps