

## 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 ship building and various types of architectural structures.

Specifications	
<b>Classifications</b>	EN ISO 14343-A : W 19 12 3 L SFA/AWS A5.9 : ER316L Werkstoffnummer : ~1.4430
<b>Approvals</b>	ABS : 1.6-3.2mm BV : 1.6-3.2mm CE : EN 13479 CWB : ER316L DNV : 1.0-4.0mm RINA : 316L BT UKCA : EN 13479 VdTÜV : 1.0-4.0mm

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

<b>Alloy Type</b>	Austenitic (with approx. 10 % ferrite) 19% Cr - 12% Ni - 3% Mo - Low C
<b>Shielding Gas</b>	I1 (EN ISO 14175)

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 Weld Metal Analysis %									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.01	1.8	0.4	0.01	0.02	12	19	2.6	0.1	0.05

Typical Weld Metal Analysis %									
FN WRC-92									
7									

Typical Wire Composition %									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.01	1.7	0.4	0.010	0.015	12.0	18.2	2.6	0.10	0.04

Typical Wire Composition %									
FN WRC-92									
7									