

ARCALOY 316L-17 PLUS

AWS A5.4: E316-17/E316L-17

FEATURES

Arcaloy 316L-17 Plus electrodes have a heavy coating and produce a concave bead with minimal ripple. The slag is virtually self-cleaning. Molybdenum increases the resistance to pitting corrosion caused by corrosive media such as sulfuric and sulfurous acids, sulphites, chlorides and cellulose solutions. Ideal for welding Types 316 & 316L stainless steels when bead appearance is important.

TYPICAL MECHANICAL PROPERTIES

Yield Stress	64 ksi, 441 MPa
Tensile Strength	83 ksi, 572 MPa
Elongation in 2"	45%

CLASSIFICATIONS AND APPROVALS

- ASME IX F No. 5
- ASME II SFA A5.4: E316-17/E316L-17
- AWS A5.4: E316-17/E316L-17
- CWB: CSA W48 E316L-17

WELDING PROCESS

- SMAW (Stick)

WELD METAL ANALYSIS

C	0.02%
Mn	0.6%
Si	0.6%
Cr	19%
Ni	12%
Mo	2.5%
Cu	0.1%
Ferrite	7 FN

INDUSTRIES

- General Fabrication
- Food and Beverage
- Shipbuilding
- Rail Road Car

ARCALOY 316L-17 PLUS continued

WELDING PARAMETERS

Diameter in (mm)	Flat Amps	Vertical Amps	Overhead Amps
1/16 (1.6)	20 - 35	15 - 25	20 - 30
5/64 (2.0)	30 - 50	25 - 35	30 - 40
3/32 (2.4)	60 - 85	40 - 60	40 - 60
1/8 (3.2)	90-120	70-80	60 - 85
5/32 (4.0)	140-165	80-90	95 - 120
3/16 (4.8)	180-210	100 - 115	125 - 150
1/4 (6.4)	205 - 290		

PART NUMBER / PRODUCT INFORMATION

Part Number	Description	UPC
251311007	AC 316L-17 3/32X12X8#HS	662303028565
251311015	AC 316L-17 1/8X14X10#HS	662303028572
251311023	AC 316L-17 5/32X14X10#HS	662303028589
251311031	AC 316L-17 3/16X14X10#HS	662303028596