

TECHNICAL DATA SHEET

BRAND NAME: MANGALAM E 316L

Classification:

AWS A /SFA 5.4 E 316L-16

RDSO Class M3

DESCRIPTION AND APPLICATIONS:

Mangalam 316 L is a Rutile Type basic coated all position welding electrode giving a very smooth and finally ripped bead. Slag control and removal is very easy. The weld metal has a superior resistance to pitting corrosion. in textile paper, petrochemical & pharmaceutical industries.

Typical applications:

- Welding Cr-Ni-Mo steels like AISI 316, 316L, 317 L
- Welding of equipment in Textile industry, Paper industry, Paint industry, petrochemical & pharmaceutical industries.
- Cladding stainless steel

CHEMICAL COMPOSITION OF WELD METAL (%)::

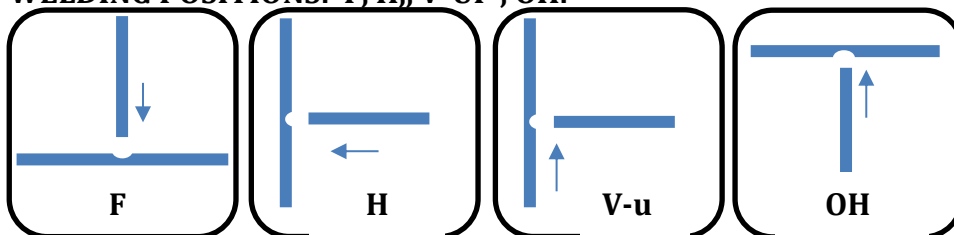
Elements	C	Mn	Si	S	P	Ni	Cr	Mo
%	0.04 Max	0.50 – 2.50	1.00 Max	0.030 Max	0.040 Max	11.00– 14.00	17.00 - 20.00	2.00 – 3.00

MECHANICAL PROPERTIES OF ALL WELD METAL:

Ultimate tensile Strength (N/mm ²)	Elongation (%)	Ferrite No.
490 Min	30 Min	3 - 7

Radiography Test II Blue Standard	Satisfactory
Storage Stability	Satisfactory

WELDING POSITIONS: F, H,, V-UP , OH.



CURRENT CONDITION: AC/ DC (+)

PACKING DATA:

Size SWG	SIZE mm	No of electrodes /Packet	No of electrodes /Cartoon	Current in Amps
12	2.50 X 350	2 Kg	10 Kg/5 Pkt	40 - 80
10	3.15 X 350	2 Kg	10 Kg/5 Pkt	60 - 100
8	4.00 X 350	2 Kg	10 Kg/5 Pkt	90 - 140
6	5.00 X 350	2 Kg	10 Kg/5 Pkt	130 - 180