

TASETO Welding Materials

Stainless Steel Electrodes

For Shielded Metal Arc Welding

RNY316LA

● Applicable Specification

JIS Z 3221 ES316L-16
AWS A5.4 E316L-16

● Identification Color

End Face: Green
Side Face: Black

● Applications and Characteristics

TASETO RNY316LA is designed to suppress the ferrite content in weld metal with excellent toughness at low temperature.

It is used for welding of equipment that for extra low temperature environment including liquid hydrogen, liquid nitrogen, and liquid helium.

RNY316LA is a lime-titania type electrode suitable for positional and its weld metal has good hot cracking resistibility.

● Notes on Usage

- * Dry the electrode at 150°C to 200°C for 60 minutes before use.
- * Remove oil and dust from the surface to be welded.
- * Keep interpass temperature at 120°C or less.

● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.026	0.49	1.73	0.022	0.006	13.01	18.93	2.12	0.10

● Mechanical Properties of All Weld Metal

	Tensile Strength (MPa)	5D Elongation (%)
Typical	545	44.5

● Impact Properties of All Weld Metal

	Absorbed Energy (J) -196°C	Lateral Expansion (mm) -196°C
Typical	36	0.83

● Other Properties of All Weld Metal

- * Typical Ferrite Content : 4.1% (Schaeffler's Diagram)

● Sizes Available, Recommended Currents (AC or DCEP)

Size (mm)	Length (mm)	Welding Current (A)	
		Flat	Vertical, Overhead
2.6	300	50~90	45~80
3.2	350	80~120	65~110
4.0	350	110~150	85~135
5.0	350	150~200	—