

# TASETO Welding Materials

Stainless Steel Electrodes

For Shielded Metal Arc Welding

## RNY316L

### ● Applicable Specification

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

### ● Identification Color

End Face: Green  
Side Face: —

### ● Applications and Characteristics

TASETO RNY316L is the first covered electrode of 18%Cr-12%Ni-2%Mo stainless steel produced in Japan.

Because of good resistibility for intergranular corrosion, it is used for welding low carbon (Type 316L) plates or castings for important chemical equipment, which may be omitted post weld solution heat treatment.

RNY316L is a lime-titania type electrode suitable for positional welding.

### ● 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.

### ● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.031	0.55	1.58	0.023	0.006	12.80	19.43	2.38	0.13

### ● Mechanical Properties of All Weld Metal

	Tensile Strength (MPa)	5D Elongation (%)	Absorbed Energy at 20°C (J)
Typical	586	42.4	100

### ● Other Properties of All Weld Metal

\* Typical Ferrite Content : 6.4% (Schaeffler's Diagram)

\* Copper Sulfate-Sulfuric Acid Test : No defects after bending (650°C × 2h PWHT)

\* 5% Sulfuric Acid Test : max. 6 g/m<sup>2</sup>·h

### ● 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	—