

HABCO 316L-16 (S)

MICRO-DENSE COATED SPRAY TRANSFER SUPER STAINLESS ELECTRODE

FEATURES

This alloy has a high molybdenum content to give added strength, even at high temperatures and to provide extra corrosion resistance to certain acids. The high quality, balance chemistry of these electrodes gives them superior welding characteristics. They are designed with a special, spray type arc transfer. This results in less heat input because a closer gap can be maintained while welding. This also makes it an easier electrode to use in all positions. The **HABCO 316L** has arc stabilizers in the coating that make them outstanding when used on AC machines. The slag is very easy to remove - virtually self-lifting. The special HABCO coating insures dense, porosity free welds. It not only retards moisture pick-up, but will automatically readjust the moisture content to a safe level once it is brought back to a drier atmosphere, without the need for re-baking.

APPLICATIONS

HABCO 316L is designed to weld type 316 stainless steel. This electrode has molybdenum added to increase its corrosion and creep strength at elevated temperatures. Chemical plants, pulp and paper, and textile dyeing industries use this alloy because of its resistance to corrosion from sulfite liquor solutions. Also used in petroleum refinery equipment and pharmaceutical equipment, as well as photographic equipment, food processing equipment and nuclear equipment.

HABCO 316L is used on grades of stainless steel where carbon content must be low, also used for CF-3M, CF-8M castings.

INSTRUCTIONS

Clean weld area of foreign material. A 60° bevel is used when welding parts 3/16" or heavier. DC reverse polarity is preferred. Use lowest amp setting possible to get good bead contour, which is usually about 20% less than for mild steel. In fabricating, tack weld at close intervals using next smallest diameter electrode. Chip slag and stainless steel wire brush tacks before welding. Use stringer beads where possible and keep close arc gap while welding. Avoid excess heat build-up. Thin sheets may have to be clamped with chill blocks to avoid excessive distortion.

Tensile Strength: up to 90,000 Psi (63 kg/mm²)

Yield Strength: up to 60,000 Psi (42 kg/mm²)

Elongation in 2": 45% • Corrosion Resistance: Very Good

Heat Resistance: Excellent - up to 2000°F (1093°C)

Current: AC or DC +

Amperage	40-80	60-120	90-150	140-220
Diameters: (in)	3/32	1/8	5/32	3/16
(mm)	2.5	3.25	4.0	5.0

- Available in TIG and WIRE form
- Certified by CWB to CSA STANDARD W48
- Conforms to AWS A5.9 E316L-16