



# Cromarod 316LV

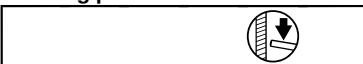
SMAW - (Stick) - MMA  
Stainless Steel

Date: 2009-02-27  
Revision: 15

## Description:

Cromarod 316LV is a rutile flux coated electrode designed specially for welding thin section acid resisting 316L austenitic stainless steels in the vertical down position. The special composition and very thin coating gives the electrode exceptionally good operating characteristics when vertical down welding of single pass butt, fillet and lap joints. Weld beads are neat and smooth with a slightly concave profile to fillets. The vertical down technique is characterised by high welding speeds and low heat input, giving enhanced productivity combined with minimum distortion. Cromarod 316LV is ideal for joining stainless steel cladding and linings.

## Welding positions:



## Coating type:

Rutile

## Welding current:

DC +, AC 0CV > 39V

## Ferrite content:

FN 6 (WRC-92)

## Corrosion resistance

Good resistance to general and intergranular corrosion in the more severe environments e.g. dilute hot acids. Good resistance to chloride pitting corrosion.

## Scaling temperature:

Approx. 850 °C in air.

## Redrying temperature:

350 °C, 2h

## Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min			0,5			17,0	11,0
Typical	0,02	0,7	0,8	0,02	0,02	18,1	11,8
Max	0,030	1,0	2,0	0,030	0,025	20,0	13,0

	Mo	Cu	V	Nb
Min	2,5			
Typical	2,7			
Max	3,0	0,5	0,1	0,1

## Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 350 MPa	490 MPa
Tensile Strength, Rm:	≥ 510 MPa	630 MPa
Elongation, A5	≥ 30%	32%
Impact energy, CV:		20 °C • 60 J

## Produkt data:

Diam.mm	Length mm	Product code	Current A	Voltage V	Kg weld metal/ kg electrodes	No. of electrodes/ kg weld metal	Kg weld metal/ hour arc time	Burn-off time/ electrode (sec.)
2,5	300	74412500	55-80	24	0,70	96	1,0	35
3,2	350	74413200	80-115	25	0,71	50	1,5	42

## Classification:

EN 1600	E 19 12 3 L R 15
AWS A5.4	E 316L-17
ISO 3581-A	E 19 12 3 L R 15

## Approvals:

CE

## Note

Core wire:  
P ≤ 0.020%  
S ≤ 0.015%  
N ≤ 0.080%