



## EAGLE 316L-16

Superior high strength alloy for welding corrosion resistant austenitic Cr-Ni stainless steel containing 2-3% molybdenum.

Certified by CWB to CSA W48

### APPLICATIONS

The **EAGLE 316L-16** electrodes are designed for the welding of type 316 chromium - nickel steel.

### PROCEDURE

AC or DC reverse polarity (+). Clean weld areas with a grinder and groove out cracks using the **EAGLE 188**. Maintain a short arc length and use stringer beads.

### GENERAL CHARACTERISTICS

The **EAGLE 316L-16** electrodes are designed for the welding of 316 type chromium – nickel steel. This alloy contains 2% to 3% molybdenum in addition to chromium and nickel to make it austenitic. Molybdenum is added to increase the corrosion resistance of this alloy to a form reaction known as pitting from sulfuric acids.

### TECHNICAL DATA

Tip Color:	Green				
Tensile Strength: Psi	Approximate 86,500				
Elongation:	Approximate 40%				
Current:	AC – DC Reverse (+)				
Sizes: (IN)		3/32	1/8	5/32	3/16
(MM)		2.50	3.25	4.00	5.00
Amperage:		30 - 80	60 - 110	110 - 150	160 - 180

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