



EAGLE 316L-16

Superior High Strength Alloy For Welding Corrosion Austenitic Cr-Ni Stainless Steel Containing 2-3% Molybdenum.

CERTIFIED BY CWS TO CSA W48

APPLICATIONS

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

PROCEDURE

Use AC or DC Reverse [+] Polarity. Clean weld areas with 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: Approx. 86,500 psi
Elongation: Approx. 40%
Shielding Gas: 75/25 AR/CO₂
or 100% CO₂
Gas Flow: 30 – 40 CFH

WELDING PARAMETERS

Current:	AC or DC Reverse [+] Polarity			
Sizes: Inches	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



≡ HIGH QUALITY WELDING PRODUCTS ≡

10077 - 166 STREET, EDMONTON, ALBERTA T5P 4Y1 • BUS: (780) 481-8082
FOR TECHNICAL ASSISTANCE CALL US TOLL FREE 1-800-447-1415