



EAGLE 316L-16 DHO

Superior Alloy Specially Designed For Vertical Down/Up And Overhead Welding Of Thin To Medium Gauge Stainless Steels Bearing Molybdenum.

APPLICATIONS

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

PROCEDURE

Use AC or DC Reverse [+] Polarity. For vertical welding, set amperage to the highest recommended setting for the diameter. Weld at a sharp angle pointing upwards whipping the electrode quickly back and forth. Excess amperage can cause the electrode to become red in colour which is normal due to the amperage levels.

GENERAL CHARACTERISTICS

The **EAGLE 316L-16 DHO** electrode possesses a unique **FAST FREEZE** coating which allows for simpler up hand and overhead welding. All position, controlled weld puddle allows for filling holes on stainless steels. This alloy contains 2%-3% molybdenum in addition to chromium and nickel to make it austenite.

TECHNICAL DATA

Tip Colour: Blue
Tensile Strength: Approx. 80,000 psi
Yield Strength: Approx. 56,000 psi
Elongation: Approx. 42%

WELDING PARAMETERS

Current:	AC or DC Reverse [+] Polarity			
Sizes:	Inches	5/64	3/32	1/8
	mm	2.00	2.50	3.25
Amperage:	35 - 55	60 - 80	90 - 110	



≡ HIGH QUALITY WELDING PRODUCTS ≡

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