

BASINOX 316L is a basic coated MMA electrode for welding similar austenitic Cr-Ni-Mo steels or cast steels. Structural works with 316L stainless steels in all positions except vertical down. The weld metal has high ductility and BASINOX 316L is recommended for welding thicker section components. Applications include wet-corrosive conditions for operating temperatures <350°C. Easy slag release and well-suited for positional welding.

Classification	
EN ISO	3581-A: E 19 12 3 L B 22
AWS	A5.4: E 316L-15

Approvals	Grade
DB	●
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Ferrite
≤ 0.025	1	0.3	≤ 0.025	≤ 0.020	18.5	11.5	2.7	5-10

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-60 °C
As Welded	≥ 420	≥ 520	≥ 30	≥ 60	≥ 32

Materials

1.4401 / 1.4404(X4CrNiMo17-12-2), 1.4435 (X2CrNiMo18-14-3)

1.4571 (X6CrNiMoTi17-12-2), 1.4583 (X10CrNiMoNb18-12)

AISI 316L

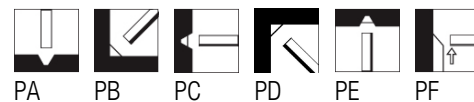
Storage

Keep dry and avoid condensation.

Re-dry at 250°-300°C for 1 hour, 5 times max.

Current condition and welding position

DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	VPMD	
				PC	Code
2.5	300	45-70	16.8	115	W000287964
3.2	350	65-120	33.29	60	W000287965
4.0	350	115-140	47.52	45	W000287966
5.0	350	130-170	71.3	30	W000287967