

Limarosta® 316L-130

EMR
SAHARA®

SMAW

CLASSIFICATION

AWS A5.4 : E316L-17
ISO 3581-A : E 19 12 3 L R 53

TEMPERATURE RANGE

Pressurized parts :-120...+350°C
Oxidation resistance :n.a

GENERAL DESCRIPTION

A rutile-basic all position stainless steel electrode for 316L or equivalent steels
Molybdenum level min. 2.7 %
High recovery (130%) providing high welding speed
Excellent side wall fusion, no undercut
Only for down hand position
Excellent for fillet welds and filling V- and X-grooves
Weldable on AC and DC+ polarity
Only available in vacuum sealed Sahara ReadyPack® (SRP)

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F

CURRENT TYPE

AC / DC +

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Mn	Si	Cr	Ni	Mo	FN [acc.WRC 1992]
0.02	0.65	1.0	18.0	11.5	2.8	4-10

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Condition	0.2% Proof strength [N/mm ²]	Tensile strength [N/mm ²]	Elongation [%]	Impact ISO-V(J)		
				+20°C	-20°C	-105°C
Required: AWS A5.4 ISO 3581-A Typical values	not required min. 320 450	min. 490 min. 510 580	min. 30 min. 25 40	not required not required 70	60	40

PACKAGING AND AVAILABLE SIZES

Unit: SRP	Diameter (mm)	3.2	4.0	5.0
	Length (mm)	450	450	450
Pieces / unit	29	23	19	
Net weight/unit (kg)	1.7	2.0	2.3	

Identification Imprint: 316L-17 / LIMAROSTA 316 L-130 Tip Color: pink

Limarosta® 316L-130: rev. EN 24

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.eu for any updated information.
Fumes: Material Safety Data Sheets (MSDS) are available on our website.

Limarosta[®] 316L-130

EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	EN 10088-1/-2	EN 10213-4	Mat. Nr	ASTM/ACI A240/A312/A351	UNS
Extra low carbon [C <0.03%]					
	X2CrNiMo17-12-2		1.4404	[TP]316L CF-3M	S31603 J92800
	X2CrNiMo18-14-3		1.4435	[TP]316L	S31603
	X2CrNiMoN17-11-2		1.4406	[TP]316LN	S31653
	X2CrNiMoN17-13-3		1.4429		
Medium carbon [C >0.03%]					
	X4CrNiMo17-12-2		1.4401	[TP]316	S31600
	X4CrNiMo17-13-3		1.4436		
		GX5CrNiMo19-11	1.4408	CF 8M	J92900
Ti-, Nb stabilized					
	X6CrNiMoTi17-12-2		1.4571	316Ti	S31635
	X6CrNiMoNb17-12-2		1.4580	316Cb	S31640
	X6CrNiNb18-10		1.4550	[TP]347	S34700
		GX5CrNiNb19-10	1.4552	CF-8C	J92710

SMAW

CALCULATION DATA

Sizes		Current type	Arc time - per electrode at max. current - [S]*	Energy E(kj)	Dep. rate H(kg/h)	Weight/ 1000 pcs (kg)	Electrodes/ kg weldmetal B	kg electrodes/ kg weldmetal 1/N
Diam. x length (mm)	Current range (A)							
3.2 x 450	90-120	DC+	68	227	1.9	60.4	28	1.67
4.0 x 450	120-160	DC+	78	376	2.5	91.0	18	1.67
5.0 x 450	160-200	DC+	81	577	3.7	143.7	12	1.72

*Stub end 35mm

WELDING PARAMETERS, OPTIMUM FILL PASSES

Diameter (mm)	Welding positions	
	PA/1G	PB/2F
3.2	110A	105A
4.0	155A	150A
5.0	175A	175A