

DESCRIPTION

Executive PLUS electrodes have a unique European formulation designed for the most discriminating operator. Improved silica-titania (AC-DC) coating resists moisture pick up. A careful selection of raw materials and an advanced manufacturing process guarantees the electrodes resist starting porosity; even under extreme humidity and when left exposed to the atmosphere for prolonged periods. Noble chemistry improves corrosion resistance in challenging environments and actual weld deposit chemistries as well as controlled ferrites with each batch.

Executive PLUS 316/316L provides superior weldability, low spatter and smooth beads with easy slag removal and can be used in all positions when welding as root runs in butt welds and thin plates in general. This low-carbon alloy, however, is not as strong at elevated temperatures as Type E316H. E316L with maximum ferrite content of 2 FN has traditionally been the choice for welding Types 304 and 316 stainless steels for cryogenic service at temperatures down to -452°F (-269°C).

APPLICATIONS & FEATURES

Executive PLUS 316/316L-17 electrodes are used principally for welding low-carbon, molybdenum-bearing austenitic alloys.

Executive PLUS features include: high current-carrying capacity, a smooth finely rippled weld bead, self-detaching slag with no residue, elimination of starting porosity, superior arc stability with excellent strike and restrike characteristics.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si
<0.025	18.5	11.5	2.8	0.8	<0.8

Tensile Strength:	79,000 PSI min	Yield Strength:	49,000 PSI min	Elongation:	39%
Charpy V-Notch:	44 ft/lb at -76°F / -60°C				

TYPICAL WELDING PARAMETERS

Process	Diameter	Length	Amperage
SMAW	3/32"	14"	40-70
AC/DC	1/8"	14"	60-100
	5/32"	14"	90-140
	3/16"	14"	120-185

STANDARD PACKAGING & HANDLING

SMAW	.093"	9-lb metal can	27-lb master box
	.125"	9-lb metal can	27-lb master box
	.156"	9.5-lb metal can	28.5-lb master box
	.187"	9.5-lb metal can	28.5-lb master box

CLASSIFICATION

AWS/SFA 5.4, Class **E316/316L-17**
Certified by the Canadian Welding Bureau (CWB) to AWS A5.4

