

## OK Tigrod 316L

Bare corrosion resisting chromium-nickel-molybdenum welding rods for welding of austenitic stainless alloys of 18% Cr - 8% Ni and 18% Cr - 10% Ni - 3% Mo-types. OK Tigrod 316L has a good general corrosion resistance, particularly against corrosion in acid and chlorinated environments. The alloy has a low carbon content which makes it particularly recommended where there is a risk of intergranular corrosion. The alloy is widely used in the chemical and food processing industries as well as in shipbuilding and various types of architectural structures.

<b>Classifications Wire Electrode</b>	SFA/AWS A5.9 : ER316L EN ISO 14343-A : W 19 12 3 L Werkstoffnummer : ~1.4430
<b>Approvals</b>	ABS ER 316L BV 316L BT CE EN 13479 CWB ER316L DNV-GL VL 316 L (I1) NAKS/HAKC 1.6 - 3.2 mm VdTUV 04270

Approvals are based on factory location. Please contact ESAB for more information.

<b>Alloy Type</b>	Austenitic (with approx. 10 % ferrite) 19% Cr - 12% Ni - 3% Mo - Low C
<b>Shielding Gas</b>	I1 (EN ISO 14175)

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	470 MPa (68 ksi)	600 MPa (87 ksi)	32 %

### Typical Charpy V-Notch Properties

Testing Temperature	Impact Value
20 °C (68 °F)	175 J (129 ft-lb)
-60 °C (-76 °F)	130 J (96 ft-lb)
-110 °C (-166 °F)	120 J (88.5 ft-lb)
-196 °C (-321 °F)	75 J (55 ft-lb)

### Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.01	1.8	0.4	0.01	0.02	12	19	2.6	0.1

### Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	N	FN WRC-92
0.01	1.7	0.4	12.0	18.2	2.6	0.04	7