

Manual Metal Arc Electrodes

Stainless Steel MMA Electrodes

Nicrex E312

SFA/AWS A 5.4-92 E316L-17
EN 1600 E 19 12 3 LR 12



Description and applications

This is a highly alloyed stainless steel electrode of unusual versatility. It deposits a ferritic/austenitic duplex weld metal with about FN60 ferrite content. Typical applications include the welding of dissimilar steel combinations such as mild or low alloy steel to stainless steel, and the welding of spring steels, nickel steels, other hardenable steels.

All-weld metal properties

	Composition wt %		AWS Mechanical	As-welded	
	Min	Max			
C		0.15	0.2% PS	450 min	N/mm ²
Si	0.70	1.20	UTS	660 min	N/mm ²
Mn	0.50	1.20	Elongation	22 min	%
S		0.02			
P		0.030	Charpy V impact values	at +20°C	40 J Typical
Cr	28.0	30.0	Ferrite level	FN 50-80	
Ni	9.0	10.5	Hardness	220-240HV	
Mo		0.5	Interpass Temp.	< 150°C	
Cu		0.3			

Current range	AC (min OCV 55) or DC +		
Size (mm)	2.5	3.2	4.0
Current (amps)	50-85	55-120	75-170