

# ARCALOY 316LF5-16

AWS A5.4: E316-16/E316L-16

## FEATURES

Arcaloy 316LF5-16 is an E316L-16 electrode where the composition has been balanced to give a weld deposit with a minimum ferrite content of 5 FN. It can be used to weld Type 304L stainless steel where the presence of molybdenum is not detrimental.

\* This item is subject to Industry Alloy Surcharges

## TYPICAL MECHANICAL PROPERTIES

Yield Stress	65 ksi, 450 MPa
Tensile Strength	83 ksi, 570 MPa
Elongation in 2"	40%

## CLASSIFICATIONS AND APPROVALS

- QPL MIL-E-22200/2 MIL-316L-16
- ASME II SFA A5.4: E316-16/E316L-16
- AWS A5.4: E316-16/E316L-16
- ASME IX F No. 5
- Certified by CWB to CSA W48

## WELDING PROCESS

- SMAW (Stick)

## WELD METAL ANALYSIS

C	0.03%
Mn	1.5%
Si	0.4%
Cr	19%
Ni	12%
Mo	2.5%
Cu	0.2%
Ferrite	6 FN

## INDUSTRIES

- Petrochemical
- General Fabrication
- Food and Beverage
- Chemical

# ARCALOY 316LF5-16 continued

WELDING PARAMETERS			
Diameter in (mm)	Flat Amps	Vertical Amps	Overhead Amps
1/16 (1.6)	20 - 35	15 - 25	20 - 30
5/64 (2.0)	30 - 50	25 - 35	30 - 40
3/32 (2.4)	40 - 70	35 - 50	40 - 60
1/8 (3.2)	65 - 100	55 - 70	60 - 85
5/32 (4.0)	100 - 145	85 - 100	95 - 120
3/16 (4.8)	130 - 190	100 - 115	125 - 150
1/4 (6.4)	205 - 290		

PART NUMBER / PRODUCT INFORMATION		
Part Number	Description	UPC
251183307	* AC 316LF5-16 3/32X9X6#HS	662303014032
251183315	AC 316LF5-16 3/32X12X10#HS	662303074685
251181806	AC 316LF5-16 1/8X14X10#HS	662303014018
251185302	AC 316LF5-16 5/32X14X10#HS	662303014049
251183109	AC 316LF5-16 3/16X14X10#HS	662303014025
251181400	AC 316LF5-16 1/4X14X10#HS	662303014001

\*Special Order