

# Excalibur<sup>®</sup> 316/316L-17

Stainless • AWS E316-17, E316L-17

## Conformances

AWS A5.4/A5.4M: 2006	E316-17, E316L-17
ASME SFA-A5.4:	E316-17, E316L-17
CWB/CSA W48-06:	E316-17, E316L-17

## Welding Positions

All, except vertical down

## Key Features

- ▶ Substantial ferrite content for crack resistance
- ▶ Q2 Lot<sup>®</sup> - Certificate showing actual deposit composition and calculated ferrite number (FN) available online

## Typical Applications

- ▶ 316 and 316L stainless steel
- ▶ ASTM A240 Type 316 and 316L
- ▶ ASTM A743 or A744 Types CF-8M and CF-3M
- ▶ For joining extra low carbon molybdenum bearing austenitic stainless steels

## DIAMETERS / PACKAGING

Diameter in (mm)	Length in (mm)	8 lb (3.6 kg) Easy Open Can	10 lb (4.5 kg) Easy Open Can
3/32 (2.4)	12 (300)	ED033110	ED033111
1/8 (3.2)	14 (350)		
5/32 (4.0)	14 (350)		
3/16 (4.8)	14 (350)		
			ED033113

## MECHANICAL PROPERTIES<sup>(1)</sup> – As Required per AWS A5.4/A5.4M: 2006

	Yield Strength <sup>(2)</sup> MPa (ksi)	Tensile Strength MPa (ksi)	Elongation %	Ferrite Number
<b>Requirements</b> AWS E316-17 AWS E316L-17	Not Specified Not Specified	520 (75) min. 490 (70) min.	30 min. 30 min.	Not Specified Not Specified
<b>Test Results<sup>(3)</sup> - As-Welded</b>	469 (68)	586 (85)	45	13

## DEPOSIT COMPOSITION<sup>(1)</sup> – As Required per AWS A5.4/A5.4M: 2006

	%C <sup>(4)</sup>	%Cr	%Ni	%Mo	%Mn
<b>Requirements - AWS E316L-17</b>	0.04 max.	17.0-20.0	11.0-14.0	2.0-3.0	0.5-2.5
<b>Typical Performance<sup>(3)</sup></b>	≤0.03	19.1-19.7	11.6-12.7	2.1-2.4	0.8-1.0
	%Si	%P	%S	%Cu	
<b>Requirements - AWS E316L-17</b>	1.00 max.	0.04 max.	0.03 max.	0.75 max.	
<b>Typical Performance<sup>(3)</sup></b>	0.61-0.72	≤0.02	≤0.01	≤0.26	

## TYPICAL OPERATING PROCEDURES

Polarity <sup>(5)</sup>	Current (Amps)			
	3/32 in (2.4 mm)	1/8 in (3.2 mm)	5/32 in (4.0 mm)	3/16 in (4.8 mm)
DC+	40-80	75-110	95-150	130-200
AC	40-80	75-110	95-150	130-200

### IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED

Fumes from the normal use of some welding products can contain significant quantities of components - such as chromium and manganese - which can lower the 5.0 mg/m<sup>3</sup> maximum exposure guideline for general welding fume. BEFORE USE, READ AND UNDERSTAND THE MATERIAL SAFETY DATA SHEET (MSDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.

<sup>(1)</sup>Typical all weld metal. <sup>(2)</sup>Measured with 0.2% offset. <sup>(3)</sup>See test results disclaimer below. <sup>(4)</sup>AWS Requirement for E316-17 is 0.08% max. carbon. <sup>(5)</sup>Preferred polarity is listed first.

*Material Safety Data Sheets (MSDS) and Certificates of Conformance are available on our website at [www.lincolnelectric.com](http://www.lincolnelectric.com)*

### TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

### CUSTOMER ASSISTANCE POLICY

The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

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Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.com](http://www.lincolnelectric.com) for any updated information.