NC-36L PREMIARC™

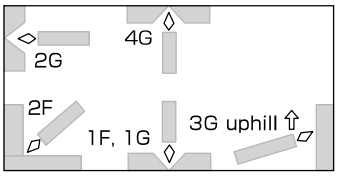
Stick electrode

Features: ▪ Applicable for 316L type steel

Classification: AWS A5.4 E316L-16

Redrying Conditions: 150~200℃x0.5~1h
Identification color: 1st Green
Polarity: AC, DCEP

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.0	250	2	20	11	300W, 130H, 280L
2.6	300	2	20	20	300W, 100H, 330L
3.2	350	5	20	36	175W, 110H, 380L
4.0	350	5	20	55	175W, 115H, 380L
5.0	350	5	20	82	175W, 115H, 380L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.03	0.04
Si	0.36	1.00
Mn	1.5	0.5~2.5
P	0.03	0.04
S	<0.01	0.03
Ni	12.0	11.0~14.0
Cr	19.4	17.0~20.0
Mo	2.2	2.0~3.0
Cu	0.11	0.75

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.0	50~75	45~65
2.6	75~95	70~90
3.2	85~120	80~115
4.0	110~160	90~140
5.0	150~200	-

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	420	-
TS (MPa)	580	483min.
El on 4d (%)	45	30min.
IV 0℃ (J)	83	-

Approvals

ABS	MG (AWS 5.4 E316L-16)
LR	316L m (CHEM)
DNV	VL316L, MG
BV	UP (E316L-16)
NK [a)]	KD316L

Note: [a)] AC