NC-316MF PREMIARC™

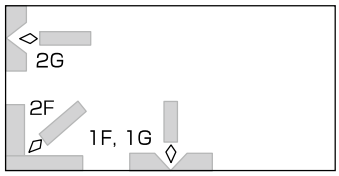
Stick electrode

Features:
- Suitable for urea plant in cryogenic temperature service
- Lime titania type

Classification: AWS -

Redrying Conditions: 150~200℃x0.5~1h
Identification color: 1st Green, 2nd Pink
Polarity: AC, DCEP

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	18	300W, 120H, 330L
3.2	300	5	20	29	300W, 110H, 330L
4.0	350	5	20	55	175W, 120H, 380L
5.0	350	5	20	83	175W, 120H, 380L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.03	0.04
Si	0.31	0.90
Mn	5.09	4.00~7.00
P	0.013	0.030
S	0.002	0.020
Ni	17.06	15.00~18.00
Cr	17.97	17.00~19.50
Mo	2.80	2.20~3.00

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G
2.6	50~85
3.2	70~115
4.0	95~145
5.0	135~180

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	370	-
TS (MPa)	520	480min.
El on 4d (%)	44	25min.
IV -257℃ (J)	70	-