

# AMERIARC

## Ameri 316 A1

### INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.4 E 316L-16	EN 1600: E 19 12 3 LR 32
DIN 8556: E 19.12.3 LR 26	ISO 3581: E 19.12.3 LR 32
NFA 81-343: EZ 19.12.3 LR 26	BS 619: E 5122 R 12

### DESCRIPTION & APPLICATION:

**Ameri 316 A1** is a special vertical position stainless steel electrode depositing weld metal of the 19% Chromium, 12% Nickel, 3% Molybdenum type for corrosion resistance. Its base materials to be welded includes 316, 316 L, 316 LN, 316 T.

It is suitable for joint welding on low carbon, unstabilised and stabilised austenitic, chemical resistant CrNiMo-steels at working temperatures up to 400°C, for corrosion resistant A wide usage in textile, pulp & paper, rayon, food & chemical industries.

### WELD METAL CHEMICAL ANALYSIS (TYPICAL WEIGHT %):

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Fe
.018	.9	.75	.01	.02	19	12	2.65	.1	bal

**Flux Color :** White-Grey

### TYPICAL MECHANICAL PROPERTIES:

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	80,000 PSI (550 MPa)
Yield Strength	56,000 PSI (390 MPa)
Elongation	42%
Hardness	Brinell 209

### WELDING CURRENT & INSTRUCTIONS:

**Recommended Current :** DC Reverse (+) or AC

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	55	75	90
Maximum Amperage	75	110	140

### PACKAGING & DIMENSIONS:

Dimensions	Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
	Length (mm)	12" (300)	14" (350)	14" (350)
Packaging	Electrodes / lb	8.8	8.8	8.8
	Electrodes / kg	4.0	4.0	4.0