

# CHS022

Extra-low Carbon Stainless Steel Covered  
Welding Rod

AWS A5.4 E316L-16  
ISO 3581-A-E (19 12 3 L) R 3 2  
ISO 3581-B-ES316L-16  
BS EN 1600-E 19 12 3 L R 3 2  
CSA W48-01 E316L-16  
JIS Z3221 D316L-16  
GB/T 983 E316L-16

**Type of Covering:** Lime-titania  
**Welding Position:** F, H, HF, OH, V  
**Type of Current:** DCEP or AC

## Features & Applications

It is suitable for welding facilities of synthetic fibre or urea, as well as for similar stainless steel structures. Also it could be used for welding structures made by category of chromium stainless steels that could not be PWHT or for welding dissimilar steels and ply steels. The weld metal has good performance of resistance to corrosion, heat and crack defect.

## Chemical Composition of Deposited Metal (%)

	C	Mn	Si	Cr	Ni	Mo	Cu	S	P
Standard	≤0.04	0.50-2.50	≤1.00	17.0-20.0	11.0-14.0	2.0-3.0	≤0.75	≤0.03	≤0.04
Typical	0.03	0.85	0.62	19.00	11.86	2.50	0.16	0.012	0.028

## Mechanical Properties of Deposited Metal (AW)

	Tensile Strength Rm (MPa)	Elongation A4 (%)
Standard	≥490	≥25
Typical	575	44

## Sizes Pieces & Recommended Current (DC+ or AC)

Size (mm)	2.0 x 300	2.5 x 300	3.2 x 350	4.0 x 400	5.0 x 400	
Pieces (2kg)	≈171	≈109	≈57	≈33	≈22	
Current (A)	F, H	30-50	50-85	85-120	120-160	150-200
	V, OH	30-50	50-70	75-100	90-135	—

## Approvals

Institute	CWB	TUV
Grade	CSA W48 E316L-16	CE

- Notice:** 1) The rod should be baked at 300 -350 for 1 hour before use.  
2) The surfaces to be welded must be cleaned away impurities of oil contamination, rust, moisture and so on.  
3) Smaller current and short arc are recommended in welding and weave beads no wider than 2.5 times of the diameter of the core rod is better.