

**selectarc**  **416**

AC/DC+

**STAINLESS STEEL****DESCRIPTION**

Very high-recovery (175%) 316L «JET» type electrode for welding and building up Cr-Ni-Mo stainless steels type; 316, 316L, 317, 317L and 318.

**CHARACTERISTICS**

- Excellent corrosion and heat resistance
- Easy slag removal
- Easy striking and restriking; the electrode will not overheat
- Ideal on thin sheets and heavy sections
- Very high deposit rate
- Low penetration and therefore less dilution

**TYPICAL APPLICATIONS**

Recommended for food and dairy industries, slaughterhouses, bottling machinery, hospital equipment, paper mills, chemical industries, etc. Ideal for 1.6 mm (1/16") thick stainless steel sections.

**PROCEDURE**

Remove any trace of oil, grease and dirt from the surface. Remove damaged metal and cracks with the **Soudotec 212 SP** or **Soudotec G12** electrode. Maintain a short arc. Remove slag between each pass. Only use perfectly dry electrodes.

**MECHANICAL PROPERTIES**

Tensile strength: 90 000 psi (620 MPa)  
 Yield strength: 68 200 psi (470 MPa)  
 Elongation: 40%  
 Impact (Charpy V): 60 J at 0°C

**WELDING PARAMETERS**

**Diameter 1.6 mm and 2.0 mm available**

Diameter:	5.0 mm (3/16")	4.0 mm (5/32")	3.2 mm (1/8")	2.5 mm (3/32")	2.0 mm (5/64")	1.6 mm (1/16")
Amperage:	140 - 220 A	140 - 215 A	90 - 140 A	55 - 105 A	45 - 70 A	35 - 50 A

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*Specialized welding alloys and technology. For technical assistance or for ordering:*

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