



Electrodes for Stainless Steel | GEMINI 316L

GEMINI 316L is a rutile high-alloy extra low carbon austenitic electrodes for welding corrosion-resistant CrNiMo-steels resistant to atmospheric corrosion. Resistant to grain disintegration of operating temperatures up to 350°C. Very smooth weld with clean weld edge. Low spatter loss and easy slag removal. For welding AISI/ ASTM 316, 316L, 316LN, 316H, 316Ti.

TYPICAL ALL-WELD METAL PROPERTIES

COMPOSITION (%)		MECHANICAL	
C – Carbon	0.03	0.2% Proof Stress	400 N/mm ²
Mn - Manganese	0.70	Tensile Strength	550 N/mm ²
Si - Silicon	0.70	Elongation (5xd)	35 %
Ni - Nickel	12.00	Reduction of area	50 %
Cr - Chromium	19.00	Impact strength ISO-V @ 0°C	60 Joule
Mo - Molybdenum	2.50	ISO-V @ +20°C	70 Joule

TYPICAL WELDING CURRENT

AC or DC +					
Diameter /Length (mm)	2.0/ 300	2.6/ 300	3.2/ 350	4.0/ 350	5.0/ 350
Current min/ max (A)	30/ 50	50/ 75	75/ 110	110/ 150	140/ 190

INTERNATIONAL STANDARD

MARKINGS & IDENTIFICATION

AWS A5.4	E 316L-16	End Tip Colour	Yellow
ISO 3581	E 19 12 3 LR 26	End side Colour	White
DIN 8556	E 19 12 3 nC R 26	Printing	G-316L/ E 316L-16

WELDING POSITION

Flat, Horizontal, Vertical-up and overhead

PACKAGING & ORDERING INFORMATION

Size	Packet	Carton
2.0mm	1 kg	20 kgs
2.6mm	1 kg	20 kgs
3.2mm	1 kg	20 kgs
4.0mm	1 kg	20 kgs
5.0mm	1 kg	20 kgs

Disclaimer: The information provided serves as a general guideline. Actual welding parameters may vary depending on the specific characteristics of the welding equipment. Additional variables to consider include weld length, plate thickness, operator proficiency, etc. Users are encouraged to assess their unique circumstances and seek professional advice as needed. It is important to acknowledge that neither we nor our affiliates can be held liable for any misuse or improper application of products.