



MUREX™ SPEDEX 309L-16

45
OCVAC
DC+

TYPICAL ALL WELD METAL MECHANICAL

PROPERTIES:	
Yield Stress	500 MPa
Tensile Strength	620 MPa
Elongation	35%
CVN Impact Values	60J av @ +20°C

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.03%	Cr: 23 %	Mn: 0.75%
Ni: 13%	Si: 0.9%	

COMPARABLE CIGWELD PRODUCTS:

Autocraft 309LSi GMAW wire
AWS A5.9: ER309LSi.
Comweld 309L Gas/TIG wire
AWS A5.9: ER309L.
Shieldcrome 309LT & FCAW wires
AWS A5.22: E309LT1-1

- ▲ A E309L-16 type stainless steel electrode.
- ▲ Designed for fillet & butt welding in all positions except vertical down.
- ▲ A smoothing running electrode producing low spatter levels.
- ▲ Ideal for the welding of matching 309 and 309L grades of stainless steel.
- ▲ Also recommended for the dissimilar welding of mild steel to stainless steel.
- ▲ Suitable as an intermediate buffer layer prior to hardfacing or as a stainless steel overlay on mild steel.

Classifications:

AS/NZS 1553.3:	E309L-16.
AWS A5.4:	E309L-16.

Packaging and Operating Data:

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
2.5	300	55	40 – 70	2.5kg	15kg – 3 x 2.5kg	SPS30925
3.2	350	30	70 – 110	2.5kg	15kg – 3 x 2.5kg	SPS30932
4.0	350	19	110 – 150	2.5kg	15kg – 3 x 2.5kg	SPS30940

SATINCROME 316L-17

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TYPICAL ALL WELD METAL MECHANICAL

PROPERTIES:	
0.2% Proof Stress	480 MPa
Tensile Strength	600 MPa
Elongation	40%
CVN Impact Values	30 J av @ -120°C.

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.025%	Mn: 0.8%	Si: 0.85%
Cr: 19.4%	Ni: 11.5%	Mo: 2.5%
S: 0.011%	P: 0.017%	

FERRITE NUMBER:

3.0 - 10.0 FN*

* - using Severn Gauge

APPROVALS:

American Bureau of Shipping AWS A5.4: E316L-17.

COMPARABLE CIGWELD PRODUCTS:

Autocraft 316LSi GMAW wire
AWS A5.9: ER316LSi
Comweld 316L Gas/TIG wire
AWS A5.9: ER316L.
Shieldcrome 316LT & FCAW wires
AWS A5.20: E316LT1-1

- ▲ Rutile Type, Stainless Steel Electrode.
- ▲ Outstanding Operator Appeal. Improved slag lift.
- ▲ All Positional (except vertical down) Welding Capabilities.
- ▲ Applications include the single and multi-pass welding of matching Molybdenum bearing stainless steels, 316 and 316L. Also suitable for the general purpose welding of other "300 series" austenitic stainless steels including 301, 302, 303 and 304/304L, 305, 3CR12 types.

Classifications:

AS/NZS 1553.3:	E316L-17.
AWS/ASME-SFA A5.4:	E316L-17.

Packaging and Operating Data:

AC (minimum 45 O.C.V.), DC+ polarity.

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Easyweld Handipack	Part No
2.0	300	87	35 – 55	2.5kg	15kg – 6 x 2.5kg		611661
2.5	300	46	40 – 70	2.5kg	15kg – 6 x 2.5kg		611662
2.5	300	46	40 – 70	1kg	12kg – 12 x 1kg		610662
3.2	350	28	75 – 110	2.5kg	15kg – 6 x 2.5kg		611663
3.2	350	28	75 – 110	1kg	12kg – 12 x 1kg		610663
4.0	350	18	110 – 150	2.5kg	15kg – 6 x 2.5kg		611664
4.0	350	18	110 – 150	1kg	12kg – 12 x 1kg		610664

Easyweld Blister Pack:

10 x 2.5mm/5 x 3.2mm rod Satincrome 316L-17 Blister Pack 322215

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Elongation	40%
CVN Impact Values	30J av @ -120°C

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.03%	Cr: 19.5 %	Mn: 0.8%
Ni: 11.5%	Si: 0.85%	Mo: 2.5%

COMPARABLE CIGWELD PRODUCTS:

Autocraft 316LSi GMAW wire
AWS A5.9: ER316LSi
Comweld 316L Gas/TIG wire
AWS A5.9: ER316L.
Shieldcrome 316LT & FCAW wires
AWS A5.20: E316LT1-1

- ▲ A E316L-16 type stainless steel electrode.
- ▲ Designed for fillet and butt welding in all positions except vertical-down.
- ▲ Speedex™ 316L-16 produces low spatter levels as well as smooth running.
- ▲ Applications include the welding of matching 316 and 316L stainless steel grades used in pipes, tanks, vessels and componentry.

Classifications:

AS/NZS 1553.3:	E316L-16.
AWS A5.4:	E316L-16.

Packaging and Operating Data:

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
2.5	300	46	40 – 70	2.5kg	15kg – 3 x 2.5kg	SPS31625
3.2	350	28	70 – 110	2.5kg	15kg – 3 x 2.5kg	SPS31632
4.0	350	18	110 – 150	2.5kg	15kg – 3 x 2.5kg	SPS31640
5.0	350	15	145 – 210	2.5kg	15kg – 3 x 2.5kg	SPS31650