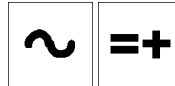


**Coating type:**  
Rutile

**Current:**



**Welding positions:**



Hilchrome 316R is our multi-purpose electrode for welding low carbon 17Cr12Ni3Mo austenitic acid resistant stainless steel grades like AISI 316, 316L. Universal in applications but typical for all industries where superior corrosion resistance is required: textile industry, paper mills, chemical industry, cellulose industry etc., resistance to general and intergranular corrosion (up to 400°C), good resistance to hot cracking. Hilchrome 316R is a core wire alloyed all-current type (AC/DC).

**Base materials to be welded:**

- ASTM/AISI Gr. 316, 316L, 316LN, 316Cb, 316Ti
- WNr 1.4583, 1.4435, 1.4436, 1.4404, 1.4401, 1.4571, 1.4580, 1.4406\*, 1.4429\*
- \* without postweld quenching
- CrNiMo 17 12 3 and similar stainless steel grades

**Applications:**

- Shipbuilding & Offshore
- Power Generation
- General fabrication & construction
- Repair & Maintenance
- Process Industry

**Chemical composition, wt. % weld metal – typical:**

C	Mn	Si	Cr	Ni	Mo
0,03	0,8	0,8	18,8	11,5	2,7

**Mechanical properties, weld metal – typical:**

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 350	≥ 540	≥ 30	20°C ≥ 47 -120°C ≥ 32

**Packaging and welding data:**

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
1,5	250	5,7	25-40
2,0	300	11,3	40-60
2,5	300	17,5	50-90
3,2	350	34,2	80-120
4,0	350	50,6	110-160