

CHS202

Stainless Steel Covered Welding Rod

AWS A5.4 E316-16
ISO 3581-A-E (19 12 2) R 3 2
ISO 3581-B-ES316-16
BS EN 1600-E 19 12 2 R 3 2
CSA W48 E316-16
JIS Z3221 D316-16
GB/T 983 E316-16

Type of Covering: Lime-titania

Welding Position: F, H, HF, OH, V

Type of Current: DCEP or AC

Features & Applications

It is used for welding structures fabricated by 06Cr17Ni12Mo2 stainless steel, which work in mediums of organic acid or inorganic acid (non-oxidizing acid). It is suitable for flat welding and fillet welding on sheets and it could be applied for welding structures made by category of high chromium steels that could not be PWHT or for dissimilar steels welding. The weld metal has good performance of corrosion-resisting, heat-resisting and crack-resisting, especially resistance to corrosion of chloridion.

Chemical Composition of Deposited Metal (%)

	C	Mn	Si	Cr	Ni	Mo	Cu	S	P
Standard	≤0.08	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	0.037	0.82	0.64	18.81	12.00	2.50	0.19	0.013	0.028

Mechanical Properties of Deposited Metal (AW)

	Tensile Strength Rm (MPa)	Elongation A4 (%)
Standard	≥520	≥30
Typical	575	42

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	
Current (A)	F	30-50	60-85	85-120	115-150	140-180
	V, OH	25-40	50-70	75-105	95-130	—

- Notice:**
- 1) The rod should be baked at 300°C-350°C 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.