

Shield-Bright 316L

Shield-Bright 316L was developed for the welding of type 316L stainless steel but can be used for other stainless steels including types 316 and 304L. In a few cases, e.g. nitric acid service, Shield-Bright 316L should not be used to weld 304L. It contains molybdenum which resists pitting corrosion induced by sulphuric and sulphurous acids, chlorides and cellulose solutions. Used widely in the rayon, dye and paper making industries.

Approvals	RS A-6(xCrNiMo 19 11 3) (C1) NAKS/HAKC 1.2 mm LR 316L (M21) ABS E316LT1-1 (C1) ABS E316LT1-4 (M21) BV 316L (C1) CE EN 13479 ClassNK KW316LG(C) (C1) CWB E316LT1-1 (C1) CWB E316LT1-4 (M21) DNV-GL VL 316L (C1) DNV-GL VL 316L (M21) KR RW316LG(C) (C1) LR 316L (C1) VdTUV 04834 (M20 M21)
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Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+
Alloy Type	Austenitic Cr-Ni-Mo

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas			
C1 shielding gas			

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
C1 shielding gas		
As Welded	-29 °C	60 J
As Welded	-196 °C	26 J

Current Range

Diameter	Current	Voltage
1.2 mm	130-220 A	24-29 V