

## CARVER 9316

### FEATURES

Complies with AWS specifications and is for welding austenitic 316 stainless steels. It gives smooth and defect-free weld metal of radiographic quality. Extremely quiet and stable arc with easy striking and re-striking.

### APPLICATIONS

CARVER 9316 is ideal for welding type 316, 316L, and 317 stainless steels in applications where low friction overlay with increased corrosion resistance are important. For repair of cracks in heavy machinery parts, earth moving equipments. Chemical vessels and plants, breweries and food equipments.

### PROCEDURE

Clean all areas to be welded and keep interpass temperatures as low as possible while welding on 300 series stainless steels. On AC/ DC use reverse polarity, heavier sections should be beveled 60°. Maintain short arc and deposit stringer beads. Avoid weaving. Deposit a number of light beads.

### TECHNICAL DATA

Alloy Type	:	Typical 316 stainless
Tensile Strength	:	620 N/mm <sup>2</sup>
Elongation	:	30-40 %
Machinability	:	Good

### RECOMMENDED CURRENT RANGE

SIZE (mm)	2.50	3.15	4.00	5.00
AMPS	50-70	85-100	115-135	140-180

**RUTILE TYPE ELECTRODE  
 FOR 18Cr - Ni11 - Mo2.5 STAINLESS STEEL**