Replaces 2209

EN ISO 3581-A-E 18 15 3 L B 1 2 mod.

HOBART TS-316LMnPro

Characteristics and Applications:

HOBART TS-316LMnPro is a basic, austenitic covered stick electrode for welding of high Ni alloy steels and stainless steels for cryogenic application. All position welding can be done with good hot cracking resistance. Excellent and stable low temperature impact toughness at -269℃.

Notes on Usage:

1. Dry the electrode at 300-350℃ for 60 minutes and keep at 100-150℃ before use.
2. Clean up the slag with stainless steel brush to prevent contaminations.
3. Keep the arc as short as possible.
4. Crater should be ground smooth.
5. Minimize heat input to reduce dilution, prevent cracking and improve impact value.

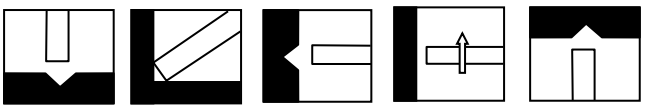
Typical Chemical Composition of Weld Metal (wt%)

	C	Mn	Si	P	S	Cr	Ni	Mo	Cu	N
Typical value	0.11	3.47	0.35	0.014	0.004	19.5	18.6	2,22	0.07	0.05

Typical Mechanical Properties of Weld Metal

	Yield stress MPa	Tensile strength MPa	Elongation %	Test Temp. ℃	Charpy V-Notch J
Typical value	410	608	34	-269	70

Welding Position



Sizes and Recommended Operating Range (AC or DC+)

Diameter (mm)		3.2	4.0
Length (mm)		350	350
Amps	F&H	90-120	100-150
	V&OH	80-110	90-130

HOBART FILLER METALS