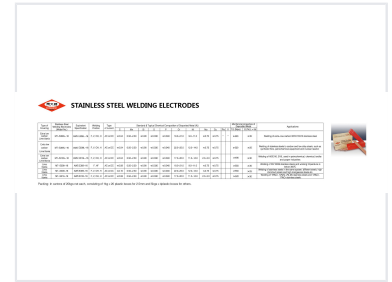


# Stainless Steel Welding Electrode

This stainless steel welding electrode conforms to AWS standards E308-16, E309-16, and E316-16. It is suitable for welding in various positions with AC or DC current.



## ADDITIONAL IMAGES



## Overview

### High-Performance Stainless Steel Welding Electrodes

These stainless steel welding electrodes are engineered for high-quality, durable welds across a wide range of industrial applications. Designed for versatility, they support both AC and DC welding currents and are compatible with various welding positions, including flat, vertical, overhead, and horizontal. With excellent corrosion resistance and precise chemical composition, these electrodes are ideal for critical industries such as petrochemical, chemical, textile, and paper manufacturing.

## Standards & Compatibility

### Welding Positions

Flat (F) • Vertical (V) • Overhead (OH) • Horizontal (H) • Horizontal-Flat (HF)

### AWS Standards

E308-16, E309-16, E316-16, E308L-16, E309L-16, E316L-16

## Technical Specifications



### STAINLESS STEEL WELDING ELECTRODES

Type of Coating	Stainless Steel Welding Electrodes (Model No.)	Equivalent Specification	Welding Position	Type of current	Standard & Typical Chemical Composition of Deposited Metal (%)										Mechanical properties of Deposited Metal		Applications	
					C	Mn	S	P	Cr	Ni	Mo	Cu	Fe	V	T.S. (MPa)	Elong. (%)		
Extra low carbon Lime titania	MT-5306L-16	AWS E306L-16	F, V, OH, H	AC or DC	≤0.04	0.30-2.50	≤0.90	≤0.030	≤0.040	18.0-21.0	9.0-11.0	≤0.75	≤0.75	-	-	≥520	≥35	Welding of extra-low carbon 00Cr21Ni10 stainless steel
Extra low carbon Lime titania	MT-5308-16	AWS E308-16	F, V, OH, H	AC or DC	≤0.04	0.50-2.50	≤0.90	≤0.030	≤0.040	22.0-25.0	12.0-14.0	≤0.75	≤0.75	-	-	≥520	≥25	Welding of stainless steels to carbon and low alloy steels, such as synthetic fibre, petrochemical equipment and nuclear reactor
Extra low carbon Lime titania	MT-5316L-16	AWS E316L-16	F, V, OH, H	AC or DC	≤0.04	0.30-2.50	≤0.90	≤0.030	≤0.040	17.0-20.0	11.0-14.0	2.0-3.0	≤0.75	-	-	≥490	≥30	Welding of AISI316, 316L used in petrochemical, chemical, textile and paper industries
Lime titania	MT-5308-16	AWS E308-16	F, HF	AC or DC	≤0.08	0.50-2.50	≤0.90	≤0.030	≤0.040	18.0-21.0	9.0-11.0	≤0.75	≤0.75	-	-	≥550	≥35	Welding of Cr/Ni/Mo stainless steels and working temperature is below 300°C
Lime titania	MT-5309-16	AWS E309-16	F, V, OH, H	AC or DC	≤0.15	0.50-2.50	≤0.90	≤0.030	≤0.040	22.0-25.0	12.0-14.0	≤0.75	≤0.75	-	-	≥550	≥25	Welding of stainless steels in the same system; different grades; high chromium steels and high manganese steels etc.
Lime titania	MT-5316-16	AWS E316-16	F, V, OH, H	AC or DC	≤0.08	0.50-2.50	≤0.90	≤0.030	≤0.040	17.0-20.0	11.0-14.0	2.0-3.0	≤0.75	-	-	≥530	≥30	Welding of 16NiCr, 16NiCr, 2% Mo stainless steels and 12NiCr, 17NiCr stainless steels

Packing: In cartons of 20kgs net each, consisting of 1kg x 20 plastic boxes for 2.5mm and 5kgs x 4 plastic boxes for others.



Detailed technical specifications and chemical composition standards for the welding electrode series.

### Available Diameters

- 2.0mm
- 2.5mm
- 3.2mm
- 4.0mm
- 5.0mm

### Recommended Current Range

Diameter (mm)	Current Range (A)
2.0	25-50
2.5	50-80
3.2	80-110
4.0	110-160
5.0	160-200

### Electrode Covering

- Extra low carbon lime titania
- Lime titania

## Logistics

### Packaging Details

Cartons of 20kg net weight, consisting of 1kg x 20 plastic boxes for 2.5mm size and 5kg x 4 plastic boxes for other sizes.

### Pre-use Requirement

Electrodes should be preheated to working temperature for one hour before use to ensure optimal performance.