

<b>International standards</b>	Material No.	~ 1.4919
	EN 1600	E 19 12 2 R
	AWS A 5.4	E 316H-16

**Characteristics and typical applications**

CARBO 316 H AC is an AC-weldable, rutile coated high carbon CrNiMo electrode with an alloyed core, primarily intended for welding 316H, The alloy has an excellent resistance to pitting and intercrystalline corrosion.

316H derivatives and stainless steels exposed to temperatures above 400°C.

Heat treatment is generally not necessary, in special cases Quench annealing at 1050°C.

**Interpass temperature** Max. 150°C

**Base materials**

1.4401	ASTM 316
1.4571	ASTM 316Ti
1.4919	ASTM 316H

**Mechanical properties of all-weld metal**

(typical values)

Tensile strength $R_m$ N/mm <sup>2</sup>	Yield strength $R_{p0.2}$ N/mm <sup>2</sup>	Elongation $A_5$ %	Hardness HB	Impact strength ISO-V J at +20° C
610	470	35	Approx.210	50

**Weld metal analysis**  
(typical, wt %)

C	Si	Mn	Cr	Ni	Mo
0,06	0,8	1,0	19	12	2,8

**Current** = + / ~ , 50 V

**Welding positions** PA, PB, PC, PD, PE, PF

**Rebaking** 1 h, 350° C + / - 10° C ( if necessary )

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg/1000	kg/packet	kg/carton
2,5 x 300	50 - 75	221	884	18,1	4,0	16,0
3,2 x 350	85 – 120	140	559	35,8	5,0	20,0
4,0 x 350	120 – 160	92	369	54,2	5,0	20,0
5,0 x 450	160 – 190	55	221	108,8	6,0	24,0

Rev. 000