



Indian Register of Shipping

Port: KANDLA
Date: 18.04.2017
Report No: KND17W001

(S) Electrode **SME 316L -16** as described below, manufactured as per **ASME SECTION II SECTION C, EDITION 2015**

DESCRIPTION:

NAME OF MANUFACTURE	:M/S. SENOR METALS PVT. LTD.
TYPE OF ELECTRODE	:S.S. ELECTRODE FOR SMAW WELDING
BRAND NAME	:SME 316L -16
AWS CLASS	:SFA 5.4, E 316L -16
WELDING POSITION	:QUALIFIED FOR ALL POSITION
SIZE (mm)	:Ø 2.0 to Ø 5.0 mm
APPLICABLE CURRENT TYPE	:AC and DC +ve

Visual Inspection carried out, reviewed chemical analysis report, tensile test(Deposited weld), weld chemistry, Fillet weld testing witnesses and radiography film reviewed .All examined with satisfactory results.

Description of results as follows:

Required test as per ASME SECTION II PART "C" EDITION- 2015, SFA 5.4
Chemical Analysis:

Electrode Size (MM)	%C	%Mn	%Si	%P	%S	%Cr	%Ni	%Mo	%Cu
Req. Value	0.04	0.5-2.5	1.0	0.04	0.03	17.0-20.0	11.0-14.0	2.0-3.0	0.75
Dia 2.50	0.030	0.66	0.90	0.040	0.006	17.59	11.38	2.44	0.50
Dia 3.15	0.026	0.71	0.85	0.040	0.005	17.74	11.38	2.48	0.33
Dia 4.0	0.027	0.67	0.86	0.032	0.006	19.90	11.04	2.89	0.21

Groove Weld for Soundness & Usability of Electrodes as per ASME SECTION II PART C EDITION-2015 – SFA 5.4

Electrode Size(MM)	Welding Position / Mechanical test / Radiography	Remark
Dia 3.15 mm	Tensile Test, Overhead (Fillet), Vertical(Fillet),Radiography Satisfactory	*Radiography Test report of No. AM / 01660 & 1661 Dtd. 31.01.2017 of M/s. Accurate Metaweld Services.
Dia 4.0 mm	Horizontal (Fillet) Radiography Satisfactory	



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All Weld Metal Tension Test :

Electrode Size (MM)		Tensile Strength(Mpa)	Yield Strength at 0.2 % offset (Mpa)	Elongation (%)	Impact at - Deg C
	Reqd. Value	490 min.	NS	30 %	NR
Dia.3.15		615.37	468.83	45.16	
Dia.4.0		639.62	471.32	32.34	



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