



FCO 316L

316L type
OPEN-ARC flux cored wire

Classification

AWS A5.22 : E309LT0-3

ISO 17633-A : T 23 12 L U NO 3

Description & Applications

OPEN ARC flux cored wire for welding of stainless steel 316L type with service temperature up to +350°C. Very low spatter and self-releasing slag. Especially used in the flat and half up / half down positions. Excellent weldability for outdoor job even when used in difficult weather conditions. Productivity improved compared to coated electrode.

Main applications: Welding of stainless steels with similar composition.

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb	Co	P	S	N
Min			0.5	17.0	11.0	2.5						
Max	0.04	1.0	2.0	20.0	13.0	3.0	0.5			0.030	0.025	
Type	0.03	0.80	1.4	19.0	12.0	2.9	0.10	0.01	0.03	0.020	0.008	0.06

Ferrite FN: 8

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	320	510	30	
Max				
Type	560	700	35	+20°C 55

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2 1.6 2.0 2.4			25 - 45	-

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