



## FCT 316L

*TIG cored wire  
For root pass on 316L*

### Classification

AWS A5.22 : R316LT1-5

### Description & Applications

Flux cored wire for TIG welding for 316L stainless steel. This product is dedicated to the root pass. Indeed this slag protects the reverse side from the oxidation by the atmosphere. Used for application with service temperature between -196°C and +350°C.

**Main applications:** Root pass for steel piping, petro chemical

#### Base materials:

UNS	Grade	EN 10088	N° Mat.
S31600	316	X5CrNiMo17-12- 2	1.4401
S31603	316L	X2CrNiMo17-12-2	1.4404
S31635	316Ti	X6CrNiMoTi17-12-3	1.4571
S30400	304	X5CrNi18-10	1.4301
S30403	304L	X2CrNi18-10	1.4306

### Typical Chemical Composition ( % )

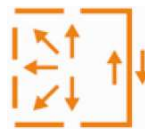
	C	Si	Mn	Cr	Ni	Mo	Cu	P	S
Min			0.5	17.0	11.0	2.0			
Max	0.03	1.2	2.5	20.0	14.0	3.0	0.75	0.04	0.03
Type	0.02	0.50	0.90	18.5	12.0	2.8	0.10	0.020	0.008

### All Weld Metal Mechanical Properties

	R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
Min		485	30	
Max				
Type	510	630	32	+20°C : 140 -196°C : 50

### Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
TIG = +	2.2	80 - 140	-	ISO 14175: I1 (Ar) 6 - 12 L/min



FT En-CN30-190731

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