



FCW 316L-M

*High productivity 316L type
Metal cored wire*

Classification

AWS A5.22 : EC316L

ISO 17633-A : T 19 12 3 L M M12 1

Description & Applications

Metal cored wire without slag for gas shielded (Ar + CO₂ or 100% Ar or Ar + O₂) arc welding for stainless steel 316L and 316 grades type stabilised with Titanium or Niobium such as 316Ti, 316Cb, 318. Especially used to the flat position.

Main applications: Current stainless steel joining

Base materials:

UNS	Grade	EN 10088	Material N°
S31600	316	X5 CrNiMo17-12- 2	1.4401
S31603	316L	X2 CrNiMo17-12-2	1.4404
S31635	316Ti	X6 CrNiMoTi17-12-3	1.4571
S31653	316LN	X2 CrNiMoN17-12-2	1.4406
S31640	318	X10 CrNiMoNb18-12	1.4583

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb	Co	P	S	N
Min		0.30	1.0	18.0	11.0	2.5						
Max	0.03	0.65	2.0	20.0	13.0	3.0	0.5			0.030	0.025	
Type	0.02	0.60	1.4	19.5	12.0	2.8	0.10	0.01	0.03	0.020	0.010	0.06

Delong : 8% - WRC (1992) : 7

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	320	510	30	
Max				
Type	450	610	35	-60°C 40

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2	100 - 280	23 - 33	10 - 25	ISO 14175 : M12 (Ar + O ₂) 12-20 l/min
	1.6	150 - 400	23 - 35		



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