



FCW 316L

*High productivity 316L type
Flux cored wire*

Classification

AWS A5.22 : E316LT0-1/-4

ISO 17633-A : T 19 12 3 L R M21(C1) 3

Description & Applications

Flux cored wire for gas shielded (Ar + CO₂) arc welding for 316L stainless steel. Flux cored wire with high productivity in down hand and fillet welding. Easy slag removal. For all type of steel construction with a service temperature does not exceed 400°C.

Main applications: Thermal Plant, piping, construction on sea coast

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	2.5			
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	2.8	0.10	0.020	0.008

FN 8 (Feritscope)

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	320	510	30	
Max				
Type	420	560	37	-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 : M21 (Ar/CO ₂) 12 - 20 l/min
	1.6	150 - 400	23 - 35	10 - 25	

FT En-CN07-190731

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.

www.fsh-welding.com - info@fsh-welding.fr

