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 + CO_2) 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 1.6	100 - 280 150 - 400	23 - 33 23 - 35	10 - 25 10 - 25	ISO 14175 : M21 (Ar/CO_2) 12 - 20 l/min