SW-316L Cored

TYPE : Rutile

AWS A5.22/ASME SFA5.22 E316LT1-1/-4
JIS Z3323 TS316L-FB1
EN ISO 17633-A-T 19 12 3 L P M/C 2

Applications

SW-316L Cored is designed for the welding of low carbon 18%Cr-12%Ni-2% Mo stainless steels or for the welding of dissimilar joints of stainless steels.

Characteristics on Usage

SW-316L Cored is a flux cored wire for all position welding to be used with CO_2 or Argon + CO_2 mixed shielding gases.
Due to ferrite contents in the weld metals austenitic structure, it has excellent crack resistance.

Notes on Usage

① Use with 100% CO_2 or Ar + 20~25% CO_2 gas.

Welding Position	Current	Shielding Gas
 1G (PA) 2F (PB) 3G (PF) 4G (PE)	DC +	CO_2/Ar+20~25%CO_2

Typical Chemical Composition of All-Weld Metal (%) (Shielding Gas: 100% CO_2)

C	Si	Mn	P	S	Cr	Ni	Mo
0.03	0.70	1.20	0.025	0.010	18.0	12.0	2.50

Typical Mechanical Properties of All-Weld Metal (Shielding Gas: 100% CO_2)

TS MPa(lbs/in²)	EL (%)	Temp. ℃ (℉)	CVN-Impact Value J (ft · lbs)
590 (85,600)	40	-20 (-4)	50 (37)

Approval

KR, ABS, LR, BV, DNV, GL, TÜV , CWB, CE, DB, CCS

I Packing(Including Ball Pac)

Dia. (mm)	0.9	1.2	1.6	Spool(kg)	5	12.5	15
(in)	.035	.045	1/16	(lbs)	11	28	33

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	0.9 (.035)	1.2 (.045)	1.6 (1/16)
F & HF	130~180	180~220	250~290
V-up,OH	100~140	120~160	-