DW-316L PREMIARC™

Flux cored wire

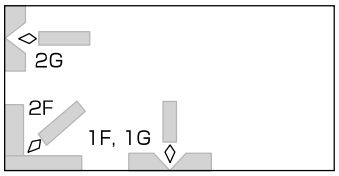
Features: ▪ Applicable for 316L type steel

Classification: AWS A5.22 E316LT0-1/4

Shielding gas: CO_2 or Ar-CO_2

Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool		Drum
0.9	5kg	12.5kg	-
1.2	-	12.5kg	150kg
1.6	-	12.5kg	-
Volume mm	235W, 110H, 230L	295W, 110H, 295L	530ϕ, 820H

Composition (all-weld metal mass%)

	Typical (CO_2)	Guaranty [a]
C	0.02	0.04
Si	0.6	1.0
Mn	1.3	0.5~2.5
P	0.02	0.04
S	0.01	0.03
Ni	12.0	11.0~14.0
Cr	18.9	17.0~20.0
Mo	2.5	2.0~3.0
Cu	0.06	0.75
Bi	>0.002	-

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G
0.9	80~150	90~130
1.2	130~270	150~220
1.6	190~320	220~270

All-weld mechanical properties

	Typical (CO_2)	Guaranty
0.2%YS (MPa)	380	-
TS (MPa)	540	483min.
El on 4d (%)	41	30min.
IV 0℃ (J)	44	-

Approvals

	CO_2	Ar-CO_2
ABS	MG	-
LR	316L S (CHEM)	
DNV	VL316L	
BV	UP	-
NK	KW316LG (C)	-
CWB	E316LT0-1	E316LT0-4