DW-316LH PREMIARC™

Flux cored wire

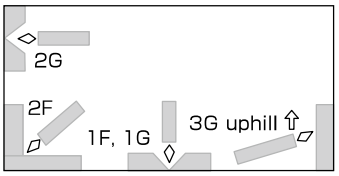
Features:
- Suitable for 18%Cr-12%Ni-2%Mo steel with high temperature heat treatment such as solution treatment
- Bi-free type

Classification: AWS A5.22 E316LT1-1/4

Shielding gas: CO_2 or Ar-CO_2

Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool
1.2	12.5kg
Volume mm	295W, 110H, 295L

Composition (all-weld metal mass%)

	Typical (CO_2)	Guaranty [a]
C	0.02	0.04
Si	0.4	1.0
Mn	1.1	0.5~2.5
P	0.02	0.04
S	<0.01	0.03
Ni	11.9	11.0~14.0
Cr	18.5	17.0~20.0
Mo	2.4	2.0~3.0
Cu	0.02	0.75
Bi	<0.0005	-

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G	3G uphill
1.2	130~270	150~220	130~180

All-weld mechanical properties

	Typical (CO_2)	Guaranty
0.2%YS (MPa)	390	-
TS (MPa)	540	483min.
El on 4d (%)	44	30min.
IV 0℃ (J)	66	-