DW-316LP PREMIARC™

Flux cored wire

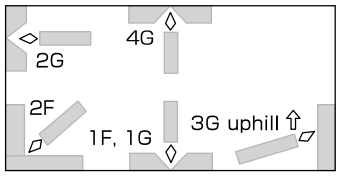
Features: ▪ Applicable for 316 and 316L type steel

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	0.8	1.0
Mn	1.3	0.5~2.5
P	0.02	0.04
S	<0.01	0.03
Ni	12.3	11.0~14.0
Cr	18.1	17.0~20.0
Mo	2.8	2.0~3.0
Cu	0.08	0.75
Bi	>0.002	-

Note: [a] Single values are maximum.

All-weld mechanical properties

	Typical (CO_2)	Guaranty
0.2%YS (MPa)	370	-
TS (MPa)	540	483min.
El on 4d (%)	43	30min.
IV 0℃ (J)	54	-

Approvals

	CO_2	Ar-CO_2
LR	-	316L S (CHEM)
DNV	VL316L	
BV	316L	-
NK	KW316LG (C)	-
CWB	E316LT1-1	E316LT1-4

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G	3G uphill	4G
1.2	130~270	150~220	130~220	150~200