DW-316LT PREMIARC™

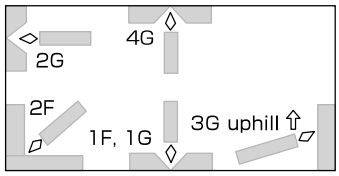
Flux cored wire

Features: ▪ Suitable for 18%Cr-12%Ni-2%Mo steel for low temperature service

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	1.2	0.5~2.5
P	0.02	0.04
S	<0.01	0.03
Ni	12.0	11.0~14.0
Cr	17.4	17.0~20.0
Mo	2.2	2.0~3.0
Cu	0.06	0.75

Note: [a] Single values are maximum.

All-weld mechanical properties

	Typical (CO_2)	Guaranty
0.2%YS (MPa)	398	-
TS (MPa)	528	483min.
El on 4d (%)	44	30min.
IV -196℃ (J)	36	27min.

Approvals

ABS	MG (AWS A5.22 E316LT1-1)
LR	316LS (CHEM & CRYO)
DNV	VL316L, MG
BV	316LBT
NK	KW316LG (C)
KR	RW316LG (C)

Note: CO_2

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G	3G uphill	4G
1.2	130~220	150~220	130~180	160~200