DW-316L-XR PREMIARC™

Flux cored wire

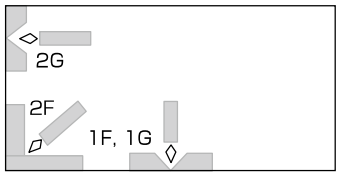
Features:
- Applicable for 316L type stainless steel
- Low Cr (Ⅵ) stainless steel flux cored wire

Classification: AWS A5.22 E316LT0-1/4

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 (wire mass%)

	Typical (Ar-CO_2)	Guaranty [a]
C	0.03	0.04
Si	0.7	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	2.4	2.0~3.0
Cu	0.03	0.75

Note: [a] Single values are maximum.

Welding parameters (A)

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

All-weld mechanical properties

	Typical (Ar-CO_2)	Guaranty
0.2%YS (MPa)	400	-
TS (MPa)	548	483min.
El on 4d (%)	42	30min.

Approvals

CWB	E316LT0-1, E316LT0-4