

AA 316L

CATEGORY FCAW Flux-Cored

TYPE Rutile flux cored stainless steel welding wire for Co2 and M21

APPLICATIONS Boilers, shipbuilding, machinery, offshore application, foundries, chemical industry, orbital tube welding etc.

PROPERTIES Flux cored wire with slag support for high productivity welding in all positions. Excellent for use on ceramic backing strips. The slag is self detaching and offers extra protection to obtain X-ray proof weld seams with practically no spatters. Better wetting and welding properties with more productivity compared to solid wires. The 0,9 and 1,0 mm can be used for all positions including vertical down and is classified as: AWS A 5.22: E 316-LT1-4

CLASSIFICATION

AWS	A 5.22: E 316-LT1-4 A 5.22: E 316-LT0-4
EN ISO	17633-A: T 19 12 3 L R M 3
DIN: W.Nr.	1.4430
DIN	8556: 19 12 3

SUITABLE FOR

1.4583	X102CrNiMoNb 18 12	316Cb	UNS S31640
1.4435	X2CrNiMo 18 14 3 (TP)	316L	.
1.4436	X4CrNiMo 17 13 3	-	.
1.4404	X2CrNiMo 17 12 2 (TP)	316L	UNS S31603
1.4406	-	316LN	UNS S31653
1.4408	X 5 CrNiMo 19 11 2	316H	.
1.4401	X4CrNiMo 17 12 2 (TP)	316	UNS S31600
1.4571	X6CrNiMo 17 12 2	316 Ti	UNS S31635
1.4580	X6CrNiMoNb 17 12 3	316Cb	.
1.4406	X2CrNiMoN 17 12 3 (TP)	316LN	.

APPROVALS TÜV (12424.00), LR, CE approved

WELDING POSITIONS:



PURE WELD DEPOSIT UNDER M21 MIXED GAS

C	Mn	Si	Cr	Ni	Mo
0,03	1,40	0,70	18,50	12,50	2,55

MECHANICAL PROPERTIES

Heat treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact energy (J) ISO-V +20°C	Impact energy (J) ISO-V -40°C	Impact energy (J) ISO-V -120°C	Hardness HRc / HV
AW with M21	382	524	46,8	>47		>32	

AW = As welded (typical Ferrite level: 10%)

WELDING PARAMETERS / PACKING

Parameters			Packing		
D (mm)	Voltage (V)	Current (A) DC+	spool type	kg / spool	kg / pallet
0.9	19-28	80-150	D-200 - KD-300	5 - 12,5	1000 / 900
1.2	23-30	150-220	D-200 - KD-300	5 - 15	1000/ 1080

REDRYING TEMPERATURE 150°C/24hr

GAS ACC. EN ISO 14175: M21, C1

