

## AA 316L TIG

**CATEGORY** FCAW Flux-Cored

**TYPE** Flux cored stainless steel welding wire for Tig welding

**APPLICATIONS** Boilers, shipbuilding, machinery, offshore application, foundries, chemical industry, root pass welding when backing gas is not available or preferred.

**PROPERTIES** Flux cored wire with slag support for high productivity welding especially for root welding. The slag is self detaching and offers a unique protection against oxidation on the reverse side of the root pass. Saving the cost for back shielding gas and purging time makes AA 316L Tig a very economical option.

**CLASSIFICATION**

AWS	A 5.22: R 316-LT1-5
EN ISO	1.4430
DIN: W.Nr.	1.4430

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** CE approved

**WELDING POSITIONS:**



**PURE WELD DEPOSIT**

C	Mn	Si	Cr	Ni	Mo	-	FS	FN
0,02	1,60	0.90	18.9	12,50	2.3	-	8	13

**MECHANICAL PROPERTIES**

Heat treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact energy (J) ISO-V +20°C	Impact energy (J) ISO-V -40°C	Impact energy (J) ISO-V -120°C	Hardness HRc / HV
as welded	440	600	38	110			

**WELDING PARAMETERS / PACKING**

Parameters			Packing		
plate thickness (mm)	Root gab (mm)	Current DC-	diameter (mm)	kg	kg / master carton
3-5	2	80-90			
6-16	2.4	90-105	2.2 x 1000	5	20
>10	2.8	90-110			

**REDRYING TEMPERATURE** 150°C/24hr

**GAS ACC. EN ISO 14175:** I1