FCW 316LP

All position 316L type
Flux cored wire

Classification

AWS A5.22 : E316LT1-1/-4 ISO 17633-A : T 19 12 3 L P M21(C1) 1

Description & Applications

Flux cored wire for gas shielded (Ar + CO_2) arc welding for 316L stainless steel. Wire with rutile fast freezing to weld in all positions. For all type of steel construction with a service temperature does not exceed 400°C.

Main applications: Thermal Plant, piping, construction on sea coast

Base materials:

UNS	Grade	EN 10088	N° Mat.
S31600	316	X5CrNiMo17-12- 2	1.4401
S31603	316L	X2CrNiMo17-12-2	1.4404
S31635	316Ti	X6CrNiMoTi17-12-3	1.4571
S30400	304	X5CrNi18-10	1.4301
S30403	304L	X2CrNi18-10	1.4306

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe
0.03	0.80	1.4	19.0	12.0	2.90	0.10	0.02	0.008	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)	
490	600	35	-60°C	50

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2	130 - 270	22 - 35	12 - 25	ISO 14175 : M21 (Ar/CO_2) 10 - 20 l/min

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