



# MIGINOX FC 316L

FCAW STAINLESS STEEL

AWS A/SFA 5.22 **E316LT1-1/4**

### CLASSIFICATION:

EN ISO 17633-B  
TS 316L PC1 1  
TS 316L PM21 1

### KEY FEATURES:

- Rutile based extra low carbon gas shielded stainless steel FCW wire
- Typical 18Cr/12Ni/2.5Mo weld deposit
- Controlled ferrite content ensures resistance against cracking
- Improved corrosion, pitting and intergranular corrosion resistance
- Stable arc and low spatter
- Excellent bead appearance
- Easy slag removal
- Radiographic weld quality

### APPROVALS: CE

### TYPICAL APPLICATIONS:

- Welding of AISI 316, 316L, 317, 317L, 318 type stainless steel and similar grade
- Welding pipes, tubes and vessels
- Cladding stainless steels
- Application in textile processing, Naval and Chemical environments, Paper and pulp, Paint and dye industries, Food processing industries

### CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


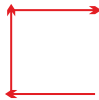
C	Mn	Si	Cr	Ni	Mo
0.04 max	0.50-2.50	1.0 max	17.0-20.0	11.0-14.0	2.0-3.0

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Specification	As Welded	485 min	30 min

With mixed gas chemical composition and mechanical properties will be higher.

### PARAMETERS - PACKING DATA:

Ø, mm	Kg/Spool	
1.2	12.5	 <b>DCEP</b> All Positions, Except Vertical Down:  <b>STORAGE / HANDLING :</b> Keep dry and follow handling instructions mentioned on the box
1.6	12.5	

Shielding Gas	Gas Flow Rate, LPM
CO <sub>2</sub>	15-20
80Ar+20CO <sub>2</sub>	18-25