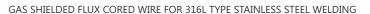




FCAW STAINLESS STEEL MIGINOX FC 316L





CLASSIFICATION: AWS A/SFA 5.22 EN ISO 17633-A

E316LT1-1/4 T 19 12 3 L R C/M 2

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

WELDING POSITION: J DCEP				
Shielding Gas	Gas Flow Rate, LPM	Stickout, mm		
CO ₂	10-20	10-20		
80Ar+20CO ₂	18-25	10-20		

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

STORAGE / HANDLING:

Keep dry and follow handling instructions mentioned on the box

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt%:								
	С	Mn	Si	Cr	Ni	Мо	S	Р
Specification	0.04 max	0.50-2.50	1.0 max	17.0-20.0	11.0-14.0	2.0-3.0	0.03 max	0.04 max

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	Voltage, V	Amperage, A	Kg/Spool	
1.2	22 - 32	120 - 300	12.5	
1.6	24 - 34	200 - 360	12.5	

EQUIVALENT:

SMAW Electrode: **Superinox 2C** GMAW Wire: **Miginox 316L** GTAW Wire: **Tiginox 316L**