

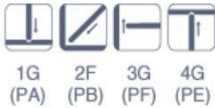
E316LT1-1

AWS A5.22 : E316LT1-1/4

Description:

E316LT1-1 is all position flux cored wire adaptable to a variety of shop and field erection applications. Designed for cryogenic applications where good weld metal toughness is required. It contains molybdenum which resists pitting corrosion induced by sulphuric and sulphurous acids, chlorides and cellulose solutions. Developed for the welding of type 316, 316L austenitic stainless steels for the low temperatures.

Welding Position:



Diameters:

1.2mm, 1.6mm

Typical Mechanical Properties:

Tensile strength(MPa):	549
Yield strength(MPa):	--
Elongation(%):	40
Impact values(≥ 27)/(-196°C):	38

Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	Cu
0.039	1.4	0.022	0.007	0.55	12.30	18.50	2.60	0.03

Welding Current:(DC+)

Diameter(mm)	1.2	1.6
Current/A	120-220	180-300
Voltage/V	20-32	20-32
Gas speed/(L/Min)	20-25	20-25

Note:

- 1.Shield gas: 100% CO₂ or 80% Ar+20% Co₂ .
2. Preheat before welding.
3. Interpass temperature: $\leq 80^{\circ}\text{C}$