E316LT1-3

AWS A5.22 : E316LT1-3

Description:

E316LT0-3 is a self-shielded, flux cored, stainless steel wire designed with a nominal weld metal composition of 19% chromium, 12.5% nickel, 2.5% molybdenum and a maximum carbon content of 0.03%. The Mo contained improves resistance to pitting and provides increased creep resistance. In addition, the low carbon content minimizes carbide precipitation and makes it more resistant to intergranular corrosion.

Welding Position:

Diameters:

0.8mm, 0.9mm, 1.0mm, 1.2mm, 1.6mm

Typical Mechanical Properties:

Tensile strength(MPa):	544
Yield strength(MPa):	--
Elongation(%):	42
Impact values(≥27J/-196℃):	49

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:(DC1)

Diameter(mm)	1.2	1.6
Current/A	120-220	180-300
Voltage/V	20-32	20-32

Note:

1.Shield gas: none

2. Preheat before welding.

3. Interpass temperature: ≤80℃