

CHARACTERISTICS

- 1, Excellent weldability with stable arc, less spatter
- 2, Uniform bead formation
- 3, Excellent wire feeding performance and high deposition rates

TYPICAL APPLICATIONS

- 1, Joining of 18%Cr-12%Ni-2%Mo steels (316 & 316L) & similar alloys ASTM A723 and A744, types CF-8M and CF-3M, etc
- 2, Many applications in chemical and textile processing equipment, pulp and paper industries
- 3, Applications in various furnace parts and parts exposed to marine environments



SIZE

1.2mm

AMPS

160-220A

CLASSIFICATION

AWS 5.22 Class E316LT1-1/4
EN ISO 17633-A-T 19 12 3 L P C/M 1

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G

EQUIVALENT TO

CHEMICAL COMPOSITIONS (Wt%), ALL WELD METAL, TYPICAL

C	Si	Mn	S	P	Ni	Cr	Mo
0.028	0.06	1.61	0.01	0.012	10.10	19.42	2.51

AVAILABLE SIZES (DIA.)

1.2mm

PACKAGING DETAILS

5/15kg Spools

CURRENT TYPE

DC+

MECHANICAL PROPERTIES, ALL WELD METAL, TYPICAL

Condition	Shielding Gas	Yield Strength (mpa)	Tensile Strength (mpa)	Elongation(%)
AW	100% CO ₂ or 80% Ar+20% CO ₂	527	590	42

Note:
Shielding gas : Gas speed 15-25L/Min

