



FCW 316L

High productivity 316L type
Flux cored wire

Classification

AWS A5.22 : E316LT0-1/-4

ISO 17633-A : T 19 12 3 L R M21(C1) 3

Description & Applications

Flux cored wire for gas shielded (Ar + CO₂) arc welding for 316L stainless steel. Flux cored wire with high productivity in down hand and fillet welding. Easy slag removal. For all type of steel construction with a service temperature does not exceed 400°C.

Main applications: Thermal Plant, piping, construction on sea coast

Base materials:

UNS	Grade	EN 10088	N° Mat.
S31600	316	X5CrNiMo17-12- 2	1.4401
S31603	316L	X2CrNiMo17-12-2	1.4404
S31635	316Ti	X6CrNiMoTi17-12-3	1.4571
S30400	304	X5CrNi18-10	1.4301
S30403	304L	X2CrNi18-10	1.4306

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe
0.03	0.80	1.4	19.0	12.0	2.80	0.10	0.02	0.008	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
490	600	35	-60°C 50

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2	100 - 280	23 - 33	10 - 25	ISO 14175 : M21 (Ar/CO ₂) 12 - 20 l/min
	1.6	150 - 400	23 - 35	10 - 25	



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