



FALCON Series
WELDING PERFECTION

FALCON E316LT1

FALCON E316LT1 is a quality rutile based stainless steel flux cored wire designed for all-positions welding with 100% CO₂ shielding. This product suitable for welding 18%Cr-12%Ni-2%Mo materials, typical applications include corrosion resistance overlay, joining of material such as type 316, 316L, CF-8M and CF-3M. Produce smooth bright and flat weld bead with easy slag removal.

Classifications

AWS A5.22	E316LT1-1
ASME SFA-A5.22M	E316LT1-1
EN ISO 17633-A:	T19 12 3 L P C1 1
EN ISO 17633-B:	TS 316L-F C1 1

Typical all weld metal composition, wt. %

	C	Mn	Si	Cr	Ni	Mo	P	S	Cu
AWS	≤0.04	0.5-2.5	≤1.0	17.0-20.0	11.0-14.0	2.0-3.0	0.04	0.030	0.75
Typical	0.026	1.41	0.55	19.01	12.10	2.62	0.022	0.006	0.04

Mechanical properties of all well metal

	Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Charpy V (J/°C)
AWS	as welded	-	485	30	-
Typical	as welded	-	565	40	-

Operating Parameters

Polarity	Shielding	Current (A)	Voltage (V)	Gas flow
DCEP	100% CO ₂	120-260 (1.2mm)	22-36 (1.2mm)	20-25 L/min (1.2mm)
		200-300 (1.6mm)	25-38 (1.6mm)	20-25 L/min (1.6mm)

Packing & Ordering Information

Wire sizes	Carton Weight	Pallet Weight	Packing method
1.2mm 1.6mm	12.5kg	1,050kg	Vacuum packed

- Proper wind-shielding measures are advisable to avoid porosity.
- Control inter-pass temperature within 16-100°C.
- Ensure base materials are free from moisture, dust, rust and oil before welding.

A Quality Product of

