TOKO E316LT1-1

Approval:
ABS、BV、CCS、
DNV、LR

Classifications:
AWS A5.22 E316LT1-1
EN T 19 12 3 LP C1
ISO 17633 B-TS316L-FC1

Flux Cored Wire for Stainless Steel

Characteristics and Applications:

ER316LT1-1is a rutile flux cored tubular wire for all positional welding using pure CO2 shielding gas. It performs with smooth arc transfer, self-releasing slag, low spatter level, fine ripple and good intergranular corrosion resistance. GFS-316L is used for welding 18%Cr-12%Ni-2% Mo stainless steels. Its typical applications include corrosion resistance overlay, joining of type 316, 316L, CF-8M, and CF-3M stainless steels pipe and tube in chemical, oil and gas refineries.

Welding Position :

Typical Chemical Composition of Weld Metal:

Alloy 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	0.03	0.5
ER316LT1-1	0.030	1.55	0.40	19.55	12.78	2.25	0.011	0.011	0.23

Typical Mechanical Properties of Weld Metal:

Mechanica properties	Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation%	Impact Value (J/°C)
AWS	—	485	30	—
ER316LT1-1	—	585	41	—

Notes on Usage:

1. Eelectric current : DC+
2. Clean up water, rust, oil on the base metal to avoid porosity and crack..
3. Shielding Gas：100%CO2 with gas flow rate of 20~25L/min and ESO of 15~20mm.
4. Proper protection on the welding place against wind is necessary during the outdoor welding.

Sizes Available and Recommended Parameters:

Dia/mm	F、H		V UP		OV	
	A	V	A	V	A	V
1.2	140-220	23-33	120-180	24-28	160-200	26-30
1.6	200-300	27-32	—		—	