

Description and Application

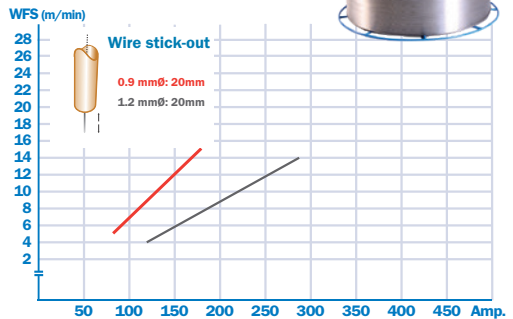
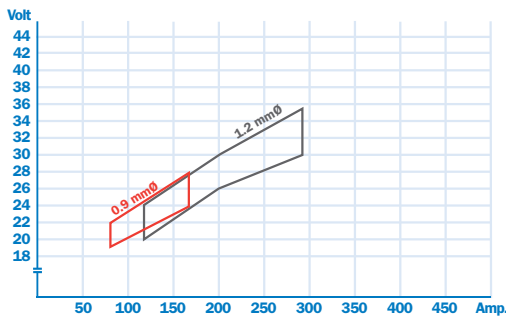
This is a rutile flux cored wire which operates with a very stable, spatter free arc producing bright, smooth weld bead surfaces and self releasing slag.

This wire is designed for welding 18%Cr-12%Ni-2.5%Mo stainless steels like type 316L or EN 1.4435. Due to the low carbon content in the weld metal, it is possible to obtain high resistance to intergranular corrosion.

DW-316LP is an all positional wire and is ideal for high productivity welding in the vertical up position.



Recommended Parameter Range, for flat position*



Typical Chemical Analysis (wt. %)*

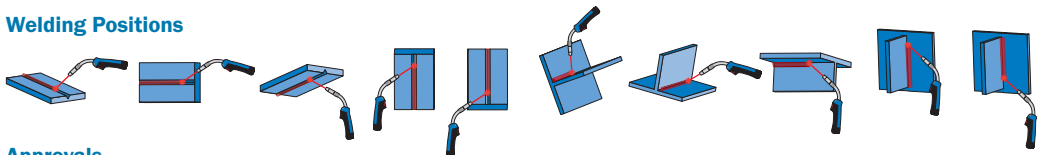
| C | Si | Mn | P | S | Ni | Cr | Mo | N | Nb | FS | FN | FNW |
|------|------|------|-------|-------|------|------|------|---|----|-----|------|-----|
| 0.03 | 0.70 | 1.40 | 0.019 | 0.006 | 12.3 | 18.4 | 2.90 | - | - | 7.0 | 11.5 | 7.8 |

Typical Mechanical Properties*

| | R _e (MPa) | R _m (MPa) | A ₅ (%) | CV(J)-20°C |
|----------|----------------------|----------------------|--------------------|------------|
| Guaranty | min.320 | min.510 | min.25 | 46 |

* The above values and parameters are for all weld metal produced using Ar+CO₂ shielding gas

Welding Positions



Approvals

| LR | DNV GL | BV | ABS | R.M.R.S | Others |
|------|----------|------|-----------|---------|--------------------|
| 316L | VL 316 L | 316L | E316LT1-4 | A-6 | TÜV, CWB, RINA, CE |