

80%Ar - 20%CO₂ / 100%CO₂
 EN ISO 17633-A T 19 12 3 L P C/M 1
 AWS A5.22 E316LT1-1/-4
 EN 1.4430

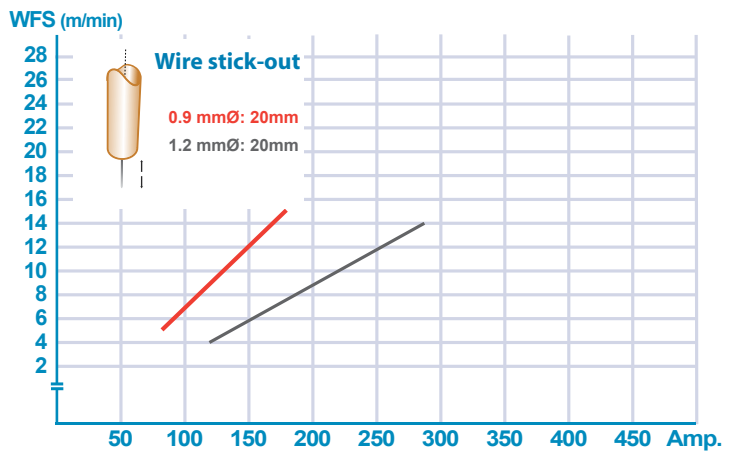
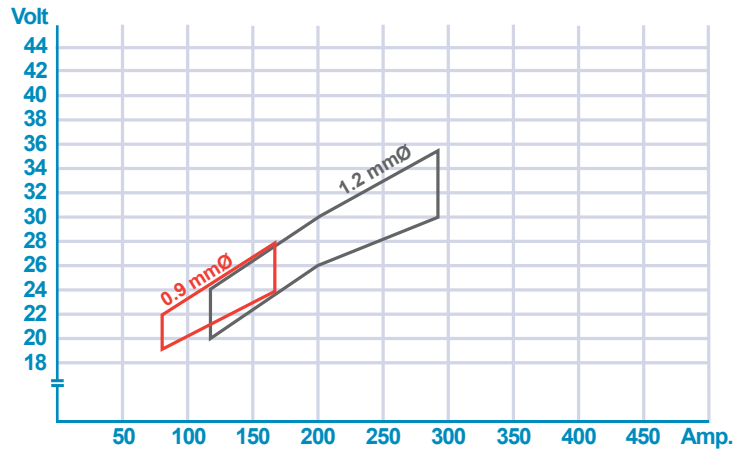
Description and Application

This is a rutile flux cored wire which operates with very stable, spatter free arcs 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.

PREMIARC™ 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. %)*

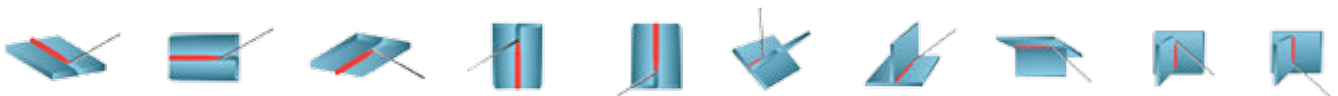
| C | Si | Mn | P | S | Ni | Cr | Mo | N | Nb | FS | FN | FNW |
|------|------|------|-------|-------|------|------|------|---|----|-----|------|-----|
| 0.03 | 0.70 | 1.40 | 0.019 | 0.006 | 12.3 | 18.4 | 2.90 | - | - | 7.0 | 11.5 | 7.8 |

Typical Mechanical Properties*

| | R _e (MPa) | R _m (MPa) | A ₅ (%) | CV (J) -20°C |
|-----------|----------------------|----------------------|--------------------|--------------|
| Guarantee | 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 | BV | GL | ABS | R.M.R.S | Others |
|------|------|------|-------|-----------|---------|---------|
| 316L | 316L | 316L | 4571S | E316LT1-4 | A-6 | CWB,TÜV |