PREMIARC™

DW-316L

80%Ar - 20%CO_2 / 100%CO_2
EN ISO 17633-A T 19 12 3 L R C1/M21 3
AWS A5.22 E316LT0-1/4
EN 1.4430
EN ISO 9606-1: FM5
EN ISO 4063: 136

Description and Application

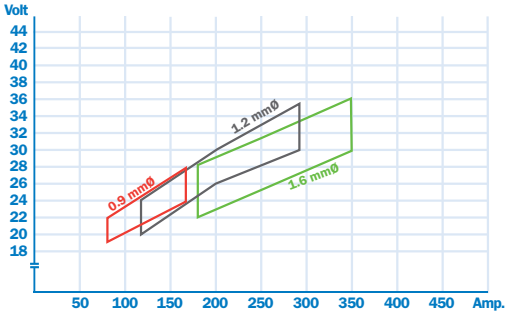
This is a rutile flux cored wire which operates with a very stable, spatter free arc producing bright, smooth weld bead surfaces and self releasing slag.

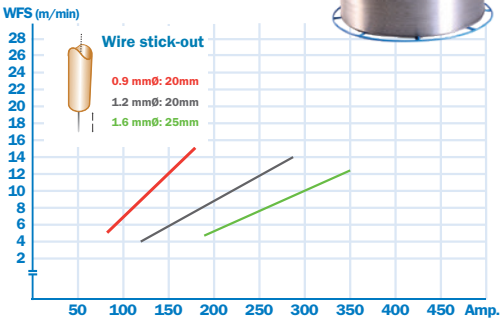
This wire is designed for welding 18%Cr-12%Ni-2.5%Mo stainless steels like type 316L or EN 1.4435. Due to the low carbon content in the weld metal, it is possible to obtain high resistance to intergranular corrosion.

DW-316L is used mainly for downhand and horizontal fillet welding.



Recommended Parameter Range, for flat position*





Typical Chemical Analysis (wt. %)*

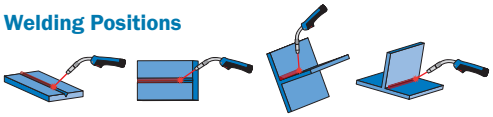
C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.03	0.60	1.60	0.020	0.006	12.2	18.7	2.80	-	-	7.7	12.8	9.7

Typical Mechanical Properties*

	R_e(MPa)	R_m(MPa)	A_5(%)	CV(J)-20°C
	430	570	39	44
Guaranty	min.320	min.510	min.25	

* The above values and parameters are for all weld metal produced using Ar+CO_2 shielding gas

Welding Positions



Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
316L	VL 316 L	316L	MG	-	TÜV, DB, CWB, CE

* The information contained or otherwise referenced herein is presented only as "typical" without guaranty or warranty. Typical data is obtained when welded and tested in accordance with EN or AWS standards. This data is intended to help the user choose the correct product. However, we do not assume any liability for correctness and information is subject to change without notice.