

**CATEGORY** FCAW Flux-Cored

**TYPE** Rutile flux cored stainless steel welding wire for CO2 and M21

**APPLICATIONS** Boilers, shipbuilding, machinery, offshore application, foundries, chemical industry, orbital tube welding etc.

**PROPERTIES** Flux cored wire with slag support for high productivity welding in all positions. Excellent for use on ceramic backing strips. The slag is self detaching and offers extra protection to obtain X-ray proof weld seams with practically no spatters. Better wetting and welding properties with more productivity compared to solid wires. The 0,9 and 1,0 mm can be used for all positions including vertical down and is classified as: AWS A 5.22: E 316-LT1-4

<b>CLASSIFICATION</b>	AWS	A 5.22: E316LT0-1
	AWS	A 5.22: E316LT0-4
	EN ISO	17633-A: T 19 12 3 L R M21 3
	F-nr	6
	FM	5
	W.Nr.	1.4430

<b>SUITABLE FOR</b>	1.4583	X102CrNiMoNb 18 12	316Cb	UNS S31640
	1.4435	X2CrNiMo 18 14 3 (TP)	316L	.
	1.4436	X4CrNiMo 17 13 3	-	.
	1.4404	X2CrNiMo 17 12 2 (TP)	316L	UNS S31603
	1.4406	-	316LN	UNS S31653
	1.4408	X 5 CrNiMo 19 11 2	316H	.
	1.4401	X4CrNiMo 17 12 2 (TP)	316	UNS S31600
	1.4571	X6CrNiMo 17 12 2	316 Ti	UNS S31635
	1.4580	X6CrNiMoNb 17 12 3	316Cb	.
	1.4406	X2CrNiMoN 17 12 3 (TP)	316LN	.

**APPROVALS** CE TÜV (TÜV (12424.00))



**TYPICAL WELD DEPOSIT WEIGHT %**

C	Si	Mn	Cr	Ni	Mo	Cu
0.028	0.51	1.63	18.9	12.1	2.75	0.11

**ALL WELD MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	RT	Impact Energy (J) ISO-V -110°C
As Welded /	380	525	45	55	35

**WELDING PARAMETERS / PACKING**

PARAMETERS	PARAMETERS	PARAMETERS	PACKING	PACKING	PACKING
D (MM)	VOLTAGE (V)	CURRENT (A) DC+	SPOOL TYPE	KG / SPOOL	KG / PALLET
0.9	19-28	80-150	D-200 - KD-300	5 - 12,5	1000 / 900
1.2	23-30	150-220	D-200 - KD-300	5 - 15	1000/ 1080

**REDRYING TEMPERATURE** 140°C / 24 hr

**GAS ACCORDING EN 14175** M21