

AA 316LP

CATEGORY FCAW Flux-Cored

TYPE Rutile flux cored stainless steel welding wire for welding in all positions.

APPLICATIONS Welding stainless steel types of the AISI 316 grade in case high weld metal quality and a attractive bead appearance are required.

PROPERTIES Smooth drop transfer and stable arc with no spatter losses. Excellent productivity and weldability, better wetting properties compared to solid wires. Excellent weld metal quality and X-ray soundness and excellent slag removal.
Excellent for use in position and down hand as well. Suitable for Co2 and M21.

CLASSIFICATION

| | |
|------------|----------------------------|
| AWS | A 5.22: E 316L T 1-4/-1 |
| EN ISO | 17633-A: T 19 12 3 L P M 1 |
| DIN: W.Nr. | 1.4430 |
| DIN | 8556: 19 12 3 L |

SUITABLE FOR Stainless steels for general use: NF A 35-573, 35-574, 35-575, 35-576 : Z2 CND 17.12, Z2 CND 17.13, Z6 CND 17.11, Z6 CND 12. ASTM/AISI : 316, 316 L, 316 LN. DIN 17 440 : X2 Cr NiMo 18.19, X2 Cr Ni Mo 18.10, X2 Cr NiMo 18.12, X5 Cr Ni Mo 18.10, X5 Cr Ni Mo 18.12 Werkstoff Nr : 1.4401, 1.4404, 1.4435, 1.4436, 1.4571, 1.4573, 1.4580, 1.4583, 1.4437. UGINE :NSM 21 S, MKS.

APPROVALS Lloyds, CE approved

WELDING POSITIONS:



ALL-WELD METAL ANALYSES %

| C | Mn | Si | Cr | Ni | Mo |
|------|------|------|-------|------|------|
| 0.03 | 1.40 | 0.70 | 18.50 | 12.5 | 2.55 |

MECHANICAL PROPERTIES

| Heat Treatment | R _{p0,2} (N/mm ²) | R _m (N/mm ²) | A ₅ (%) | Impact Energy (J) ISO-V | | | Hardness HRC / HV |
|----------------|---|--|-----------------------|-------------------------|-------|-------|----------------------|
| | | | | -20°C | -40°C | -60°C | |
| AW with M21 | 382 | 524 | 46.8 | >47 | >32 | | |

AW: as welded

WELDING PARAMETERS / PACKING

| Welding Parameters | | | Packing | | |
|--------------------|-------------|-------------|---------------|------------|-------------|
| D (mm) | Voltage (V) | Current (A) | Spool type | kg / spool | kg / pallet |
| 1.0 | 20-29 | 100-180 | D-200 / K-300 | 5 / 12,5 | 1005 / 900 |
| 1.2 | 23-30 | 150-220 | D-200 / K-300 | 5 / 15 | 1005 / 1080 |

REDRYING TEMPERATURE 150°C/24hr

GAS ACC. EN ISO 14175: M21