

AA 316L TIG

CATEGORY	FCAW Flux-Cored							
TYPE	Flux cored stainless steel welding wire for Tig welding							
APPLICATIONS	Boilers, shipbuilding, machinery, offshore application, foundries, chemical industry, root pass welding when backing gas is not available or preferred.							
PROPERTIES	Flux cored wire with slag support for high productivity welding especially for root welding. The slag is self detaching and offers a unique protection against oxidation on the reverse side of the root pass. Saving the cost for back shielding gas and purging time makes AA 316L Tig a very economical option.							
CLASSIFICATION	AWS	A 5.22: R 316-LT1-5						
	EN ISO	1.4430						
	DIN: W.Nr.	1.4430						
SUITABLE FOR	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 approved							
WELDING POSITIONS:								
PURE WELD DEPOSIT								
C	Mn	Si	Cr	Ni	Mo	-	FS	FN
0,02	1,60	0.90	18.9	12,50	2.3		8	13
MECHANICAL PROPERTIES								
Heat treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact energy (J) ISO-V +20°C	Impact energy (J) ISO-V -40°C	Impact energy (J) ISO-V -120°C	Hardness HRc / HV	
as welded	440	600	38	110				
WELDING PARAMETERS / PACKING								
Parameters				Packing				
plate thickness (mm)	Root gab (mm)		Current DC-	diameter (mm)	kg	kg / master carton		
3-5	2		80-90	2.2 x 1000	5	20		
6-16	2.4		90-105					
>10	2.8		90-110					
REDRYING TEMPERATURE	150°C/24hr							
GAS ACC. EN ISO 14175:	I1							