

ES FC 316LT

Type Rutile

FCAW

E316LT1-4

ESWECO
The Art of Welding

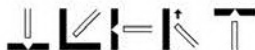
Description

ES FC 316LT is a flux-cored wire for the out-of-position welding of 316 and 316L type stainless steels where increased resistance to pitting corrosion is required. This is particularly relevant when it comes to attack by chloride solutions and sulphuric acid. The weld metal composition is such that the stabilised 321 and 347 stainless steels may also be welded.

Shielding gas
Ar+20%CO₂.

Current

DC+



Classifications

EN 12073 T 19 12 3 L P M 2
SFA/AWS A5.22 E316LT1-4

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo
0.023	0.9	1.2	19.0	12.0	2.5

Typical mech. Properties all weld metal

Yield stress, MPa	475
Tensile strength, MPa	615
Elongation, %	36

Welding parameters

Diameter, mm

1.2

Welding current, A

140-240

Arc voltage, V

24-30