

RAAJCORED316L

STAINLESS STEEL GAS SHIELDED FLUX CORED ARC WELDING WIRE

Classification : AWS: A5.22 E316L-T1
JIS Z 3323 TS316L-FC1

Description : Rutile type Gas shielded Flux cored arc welding wire, austenitic structure weld metal, smooth and stable arc, low spatter loss and easy slag remove. Low carbon content in weld metal to get good crack and inter-granular corrosion resistance. High welding performance, austenite weld metal contains adequate ferrite to get good crack resistance, Good low temperature impact toughness and corrosion resistance.

Typical Application :
- Suitable for welding severe acid and high heat resistance required SUS316 stainless steel.

TYPICAL ALL WELD CHEMICAL COMPOSITION (Wt. %)

C	Mn	Si	Ni	Cr	Mo
0.030	1.45	0.50	12.40	18.90	2.35

TYPICAL ALL WELD MECHANICAL PROPERTIES:

UTS (N/mm ²)	Elongation %
550	42

DIEMENSION, CURRENT CONDITION & RECOMANDED PARAMETERS

Size (mm)	Dia	1.20	1.60
Polarity		DC+	DC+
Ampere(A)	Flat and Horizontal position	160~250	200~300
	Vertical/overhead position	100~140	-----
Shield	Gas	CO ₂	CO ₂

Note: - Use General CO₂ Welding Machine with proper feed roller pressure.