

FLUX CORED WIRE : STAINLESS STEEL

SARTHAK SS 316L (E 316LT1-1)

AWS-A/SFA5.22E316LT1-1

Applications

It is used for welding of 18% Cr, 12% Ni & 2.50% Mo steel also use for welding of AISE 316L & 317L type of stainless steel in chemical plant, paint, pulp paper & textile industries,CF-8M,CF-3M

Characteristics on Usage

SARTHAK SS 316L (E 316LT1-1) is an extra low carbon rutile coated all position stainless steel flux core welding wire with Co₂ gas shielding. It gives the weld deposit of 18% Cr, 12% Ni & 2% Mo etc. It runs smoothly & gives uniform weld metal deposit with easily slag removal. The weld metal is highly resistance to intergranular corrosion. Weld metal is of radiographic quality with easy slag removal and low spatters.

Welding Positions



1G 2F 3G 4G

Recommended Stick Out

15-20mm

Shielding Gas

Carbon Dioxide (CO₂) shielding

Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	P%	Cr %	Ni %	Mo %	Cu %
Typical Values	0.030	1.50	0.70	0.030	18.50	12.05	2.50	0.1
Spec. Reqd.	0.040 Max	0.50-2.50	1.0 Max	0.040 Max	17-20	11-14	2.0-3.0	0.50 Max

Mechanical Properties Of Weld Metal

Property	U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
Typical Values	580	38
Spec. Reqd.	485 Min	30 Min

Welding Parameters (DC + VE)

Diameter (mm)	Flat		Vertical - Up		Overhead	
	(A)	(V)	(A)	(V)	(A)	(V)
1.20	160-210	26-30	120-210	22-26	160-210	26-30
1.60	190-250	26-30	160-250	21-27	190-250	26-30

Packing

12.5 kgs. vaccum packed plastic spool.