

SW-316L Cored

AWS A5.22/ASME SFA5.22 E316LT1-1/-4
EN ISO 17633-A-T 19 123 L P M/C 2

TYPE: Rutile

Applications

SW-316L Cored is designed for the welding of low carbon 18%Cr-12%Ni-2% Mo stainless steels or for the welding of dissimilar joints of stainless steels.

Characteristics on Usage

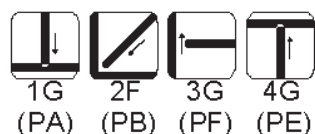
SW-316L Cored is a flux cored wire for all position welding to be used with CO₂ or Argon + CO₂ mixed shielding gases.

Due to the ferrite content in the weld metal's austenitic structure, it has excellent crack resistance.

Notes on Usage

Use with 100% CO₂ or Ar + 20~25% CO₂ gas.

Welding Position



Current

DC +

Shielding Gas

CO₂ or Ar+20~25% CO₂

Typical Chemical Composition of All-Weld Metal (%) (Shielding Gas: 100% CO₂)

C	Si	Mn	P	S	Cr	Ni	Mo
0.03	0.70	1.20	0.025	0.010	18.0	12.0	2.50

Typical Mechanical Properties of All-Weld Metal (Shielding Gas: 100% CO₂)

TS MPa	EL (%)	Temp. °C	CVN-Impact Value J
590	40	-20	50

Approval

KR, ABS, LR, BV, DNV, GL,
TÜV, CWB, CE, DB, CCS

Packing

Dia. (mm) 1.2

Spool(kg) 15

Sizes Available and Recommended Currents (Amp.)

Size mm	1.2
F & HF	180~220
V-up,OH	120~160

Diam.	15 kg Spool
1.2mm	HKSW316L12

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