

FCAW

# DW-316LP-XR

**PREMIARC™**

## Flux cored wire

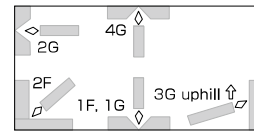
- Features:**
- Applicable for 316L type stainless steel
  - Low Cr (VI) stainless steel flux cored wire

**Classification:** AWS A5.22 E316LT1-1/4

**Shielding gas:** CO<sub>2</sub> or Ar-CO<sub>2</sub>

**Polarity:** DCEP

### Welding Positions:



## Packaging data

φ mm	Spool
1.2	12.5kg
<b>Volume mm</b>	295W, 110H, 295L

## Composition (wire mass%)

	Typical (Ar-CO <sub>2</sub> )	Guaranty <sup>a</sup>
<b>C</b>	0.03	0.04
<b>Si</b>	0.8	1.0
<b>Mn</b>	1.2	0.5~2.5
<b>P</b>	0.02	0.04
<b>S</b>	<0.01	0.03
<b>Ni</b>	12.5	11.0~14.0
<b>Cr</b>	19.0	17.0~20.0
<b>Mo</b>	2.8	2.0~3.0
<b>Cu</b>	0.05	0.75

Note: <sup>a</sup>Single values are maximum.

## All-weld mechanical properties

	Typical (Ar-CO <sub>2</sub> )	Guaranty
<b>0.2%YS (MPa)</b>	429	-
<b>TS (MPa)</b>	566	483min.
<b>El on 4d (%)</b>	41	30min.

## Approvals

<b>ABS*</b>	MG (AWS A5.22 E316LT1-4)
<b>CWB</b>	E316LT1-1, E316LT1-4

Note: \*Ar-25%CO<sub>2</sub>

## Welding parameters (A)

φ mm	1F, 1G, 2F	2G	3G uphill	4G
1.2	130~270	150~220	130~220	150~200