

FCAW

DW-316H

PREMIARC™

Flux cored wire

Features:

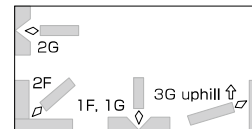
- Suitable for 18%Cr-12%Ni-2%Mo steel for high temperature service
- Bi-free type

Classification: AWS A5.22 E316T1-1/4

Shielding gas: CO₂ or Ar-CO₂

Polarity: DCEP

Welding Positions:



Packaging data

φ mm	Spool
1.2	12.5kg
Volume mm	295W, 110H, 295L

Composition (all-weld metal mass%)

	Typical (CO ₂)	Guaranty ^a
C	0.05	0.08
Si	0.4	1.0
Mn	1.1	0.5~2.5
P	0.02	0.04
S	<0.01	0.03
Ni	11.6	11.0~14.0
Cr	18.2	17.0~20.0
Mo	2.4	2.0~3.0
Cu	0.05	0.75
Bi	<0.0005	-

Welding parameters (A)

φ mm	1F, 1G, 2F	2G	3G uphill
1.2	130~270	150~220	130~180

Note: ^a Single values are maximum.

All-weld mechanical properties

	Typical (CO ₂)	Guaranty
0.2%YS (MPa)	390	-
TS (MPa)	570	518min.
EI on 4d (%)	41	30min.
IV 0°C (J)	68	-