

Description and Application

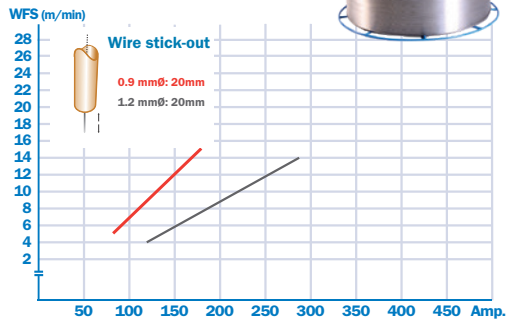
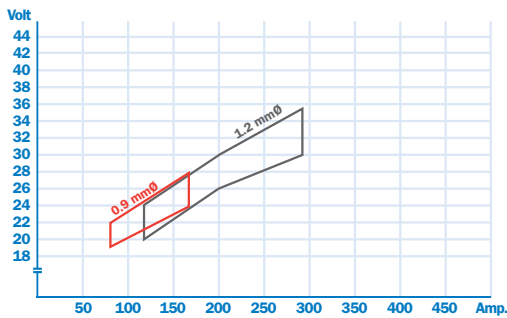
This is a rutile flux cored wire which operates with a very stable, spatter free arc producing bright, smooth weld bead surfaces and self releasing slag.

This wire is designed for welding 18%Cr-12%Ni-2.5%Mo stainless steels like type 316L or EN 1.4435. Due to the low carbon content in the weld metal, it is possible to obtain high resistance to intergranular corrosion.

DW-316LP is an all positional wire and is ideal for high productivity welding in the vertical up position.



Recommended Parameter Range, for flat position*



Typical Chemical Analysis (wt. %)*

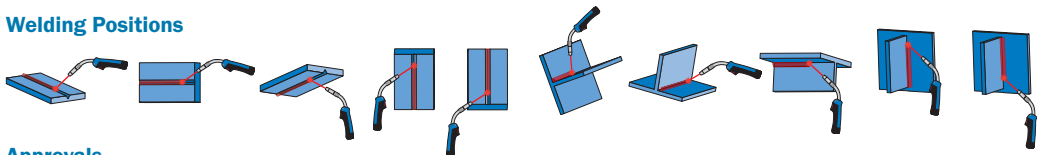
C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.03	0.70	1.40	0.019	0.006	12.3	18.4	2.90	-	-	7.0	11.5	7.8

Typical Mechanical Properties*

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)-20°C
Guaranty	430	570	40	46
	min.320	min.510	min.25	

* The above values and parameters are for all weld metal produced using Ar+CO₂ shielding gas

Welding Positions



Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
316L	VL 316 L	316L	E316LT1-4	A-6	TÜV, CWB, RINA