

SW-316L Cored

Classification

AWS AWS A5.22/ ASME SFA-5.22 E316LT1-1/-4
JIS Z 3323 TS316L-FB1
EN ISO 17633-A-T 19 12 3 L P M21/C1 2

Welding Positions



Features

- Good performance in all positions

Polarity

DC +

Application Areas

- 18%Cr-12%Ni-2%Mo stainless steels

Shielding Gas

100% CO2
Ar+20~25% CO2

Approvals

ABS	BV	CCS	DNV	KR	LR	NK	RINA	RS	CWB	CE	DB	TUV
✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓

Typical Chemical Composition of All-Weld Metal (wt%)

Shielding Gas	C	Si	Mn	P	S	Cu	Ni	Cr	Mo
100% CO2	0.02	0.9	1.3	0.013	0.008	0.03	11.8	17.5	2.6
Ar+20% CO2	0.02	0.9	1.4	0.013	0.008	0.03	11.7	17.5	2.6

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
100% CO2	550(80)	45	-20(0)	55(41)
			-60(-75)	45(33)
Ar+20~25% CO2	555(80)	42	-20(0)	55(41)
			-60(-75)	45(33)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)	Packaging
1.2 (0.045)	160~220	Spool 5kg(11lbs), 12.5(27.6lbs), 15kg(33lbs)
1.6 (1/16)	250~290	

SMW

GMW

GTW

FCW

Metal-cored Wire

SAW Wire

SAW Flux