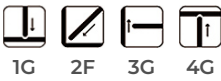


SW-316LT

Classification

AWS AWS A5.22/ ASME SFA-5.22 E316LT1-1/-4
JIS Z 3323 TS316L-FB1

Welding Positions



Features

- Good impact value at cryogenic temperature
- Good performance in all position

Polarity

DC +

Application Areas

- Cryogenic service such as LNG storage tank
- 18%Cr-12%Ni-2%Mo stainless steels

Shielding Gas

100% CO2
Ar+20~25% CO2

Approvals

ABS
✓

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

Shielding Gas	C	Si	Mn	P	S	Cu	Ni	Cr	Mo
100% CO2	0.02	0.8	1.5	0.015	0.009	0.02	12.2	17.2	2.2
Ar+20% CO2	0.02	0.8	1.5	0.015	0.009	0.02	12.2	17.2	2.2

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
100% CO2	535(78)	47	-196(-320)	32(24)
Ar+20~25% CO2	542(79)	46	-196(-320)	33(24)

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	