Exocor
1.888.317.2209 tel
1.855.317.2205 fax
exocor.com

Flux Cored Arc Welding

DW-316LP

Rutile type flux cored wire for low carbon 18%Cr-12%Ni-2%Mo stainless steel

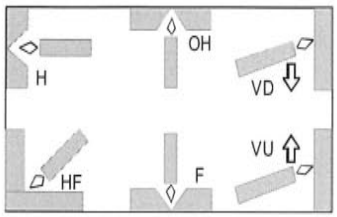
Classification: ASME / AWS A5.22 E316LT1-1/4
EN 12073 T 19 12 3 L P C/M 1
JIS Z3323 YF316LC

Features : ▪Applicable for 316 and 316L type steel
▪Suitable for butt and fillet welding in all positions including vertical downward
▪Lower carbon content than **DW-316**

Shielding gas : CO_2 or Ar-CO_2 mixture

Polarity: DC-EP

Welding positions:



Chemical composition of all-weld metal (%) as per AWS (Shielding gas: CO_2)

	C	Si	Mn	P	S	Ni	Cr	Mo
Example	0.028	0.60	1.50	0.021	0.008	12.65	18.35	2.68
Guaranty	≦0.040	≦1.00	0.50~2.50	≦0.040	≦0.030	11.00~14.00	17.00~20.00	2.00~3.00

Mechanical properties of all-weld metal as per AWS (Shielding gas: CO_2)

	0.2%OS (MPa)	TS (MPa)	El (%)	IV (J)
Example	370	540	43	0°C: 54
Guaranty	-	≧485	≧30	-

Recommended welding parameters

Dia.	1.2mm	Dia.	1.2mm
F, HF	130~270A	OH	150~200A
H	150~220A	VD	150~200A
VU	130~220A		

VD position: multi-pass welding is not recommendable.

Approvals

NV	BV	NK	Others
316L	316L	KW316LG(C)	CWB

Packages

Dia. (mm)	Type	Weight (kg)
1.2	Spool	12.5