

EXECUTIVE 316/316L

STAINLESS STEEL

FLUX CORED WIRE TECHNICAL DATA SHEET

DESCRIPTION

Executive 316/316L provides superior weldability, low spatter and smooth beads with easy slag removal. The typical molybdenum gives improved resistance to pitting and crevice corrosion over grades 308L and 309L, particularly in the presence of chlorides.

This wire is designed to be used in the flat/horizontal position. Low carbon in this filler metal reduces the possibility of intergranular carbide precipitation. This increases the resistance to intergranular corrosion without the use of stabilizers such as niobium or titanium. Strength of this low-carbon alloy, however, is less than that of the niobium-stabilized alloys or Type 316H at elevated temperatures.

APPLICATIONS & FEATURES

Used for welding similar alloys (containing 2% molybdenum) such as AISI316, 316L, 316Ti and 318; also for high temperature service applications. The presence of molybdenum which resists pitting corrosion caused by sulphuric acid, chlorides and cellulose solutions also provides increased creep residence at elevated temperatures.

This is also available in a thin gauge (TG) **Executive 316/316LTG** in .045" diameter for thin plate welding. It offers wider current ranges (as low as 85 Amps) typically only achieved with costly .035" wire, thus offering a substantial savings.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	
0.02	17.92	11.32	2.27	1.13	0.94	0.03	0.01	0.23	
Tensile Strength:		81,800 PSI min						Elongation:	37%
Yield Strength:		57,500 PSI min							

TYPICAL WELDING PARAMETERS

Diameter	Voltage	Amperage	WFS (in/min)	Shielding Gas*
.045" TG	18-21	85	140	100% CO ₂ or Ar + 20-25% CO ₂
.045" TG	26-29	165	300	
.045" TG	28-34	215	500	
.045"	24	130	225	100% CO ₂ or Ar + 20-25% CO ₂
.045"	27	175	320	
.045"	30	240	530	
.062"	27	195	152	100% CO ₂ or Ar + 20-25% CO ₂
.062"	31	260	260	
.062"	34	320	360	

*Shielding gas flow rate 35 to 50 CFH. For 100% CO₂ use two volts higher than shown

STANDARD PACKAGING

FAW	33-lb plastic spools	1,980-lb pallet
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CLASSIFICATION

AWS/SFA 5.22, Class **E316/316LT0-1/4**
Certified by CWB to CSA W48, Class E316/316LT0-1/4

