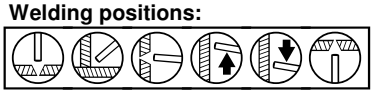
Cromacore DW 316LP

FCAW - Flux cored arc welding
Stainless Steel

Date:	2007-05-25
Revision:	12

Description:
Cromacore DW 316LP is a rutile flux cored wire intended for welding the 19% Cr / 12% Ni / 3% Mo type stainless steels. The wire has been specially designed for fully positional welding at high welding currents. Suitable also for related stabilised grades if service temperature is below 400°C. Cromacore DW 316LP operates with a very stable, spatter free arc and produces a bright, smooth weld bead surface and self-releasing slag. Ideal for high productivity welding in the vertical position.

Welding positions:



Welding current:
DC+

Deposition efficiency:
87%

Shielding gas:
M21, 80% Ar + 20% CO2, 22-25 l/min
C1, 100% CO2, 22-25 l/min

Stick-out:
15-25 mm

Ferrite content:
FN 9

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min			0.5			17.0	11.0
Typical	0.03	0.8	1.5	0.022	0.011	18.6	12.4
Max	0.04	1.0	2.0	0.030	0.025	20.0	13.0

	Mo	Cu	V	Nb
Min	2.5			
Typical	2.9	0.067	0.1	0.08
Max	3.0	0.5	0.2	0.1

Mechanical properties

	Specified	Typical
Yield strength, Rp0.2%:		430 MPa
Tensile Strength, Rm:	≥ 510 MPa	600 MPa
Elongation, A5	≥ 30%	36%
Impact energy, CV:		–20°C • 40 J

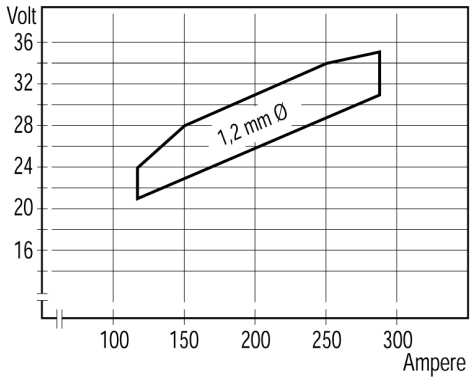
Classification:

AWS A5.22	E 316LT1-4/-1
ISO 17633-A	T 19 12 3 L P M/C 1

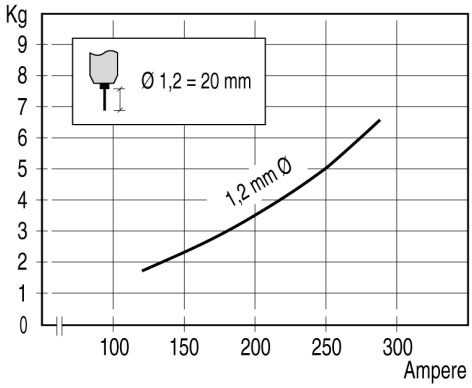
Approvals:

GL	4429S
LR	316L S
TÜV	09142.00
DNV	316L
CE	

Recommended parameter range:



Deposition rate per hour:



Product data:

Diam.mm	Product code	Spool weight
1,2	95741012	15 kg BS300
1,2	95741112	5 kg BS200

Note

Strip:
S ≤ 0.03%
P ≤ 0.04%
N ≤ 0.06%