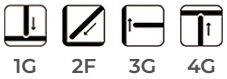
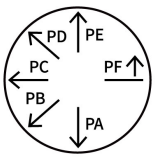
SW-316HBF

Classification

AWS AWS A5.22/ ASME SFA-5.22 E316(H)T1-1/4
JIS Z 3323 TS316H-BiF-FC1
EN ISO 17633-B T 316H F M21/C1 2

Welding Positions





Features

- Designed for welding with 100% CO2 or Ar+15~25% CO2 shielding gas
- Excellent all position weldability
- Smooth and stable arc with a fast freezing slag

Polarity

DC +

Application Areas

- Welding of 18%Cr-12%Ni-2% Mo stainless steels for high temperature service.

Shielding Gas

100% CO2
Ar+15~25% CO2

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

Shielding Gas	C	Si	Mn	P	S	Cu	Ni	Cr	Mo
100% CO2	0.05	0.7	1.6	0.016	0.008	0.02	12.5	18.2	2.7
Ar+20% CO2	0.05	0.7	1.5	0.016	0.008	0.02	12.5	18.2	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	577 (83)	42	-20 (0) -60 (-75)	70 (52) 60 (44)
Ar+20% CO2	575 (84)	42	-20 (0) -60 (-75)	70 (52) 60 (44)

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	