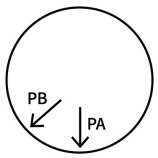
Supercored 316L

Classification

AWS AWS A5.22/ ASME SFA-5.22 E316LT0-1/-4
JIS Z 3323 TS316L-FB0
EN ISO 17633-A-T 19 12 3 L R M21/C1 3

Welding Positions





Features

- Flat and horizontal fillet position welding
- High deposition rate and efficiency

Polarity

DC +

Application Areas

- 18%Cr-12%Ni-2%Mo stainless steels

Shielding Gas

100% CO2
Ar+20~25% CO2

Approvals

BV	DNV	LR	CE	DB	TUV
✓	✓	✓	✓	✓	✓

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

Shielding Gas	C	Si	Mn	P	S	Cu	Ni	Cr	Mo
100% CO2	0.02	0.5	1.3	0.018	0.007	0.03	12.4	18.8	2.6
Ar + 20% CO2	0.03	0.6	1.4	0.018	0.007	0.03	12.3	18.9	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	539 (78)	34	-20 (0)	49 (36)
Ar+20~25% CO2	537 (78)	42	-20 (0)	46 (34)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)	Packaging
1.2 (0.045)	140~210	Spool 5kg(11lbs), 12.5(27.6lbs), 15kg(33lbs)
1.6 (1/16)	180~290	