

PRODUCT NAME

Supercored 316L

CONFORMANCES

- **AWS** : A5.22/ASME SFA5.22 E316LTO-1/-4
- **JIS** : Z3323 TS316L-FB0
- **EN** : ISO 17633-A-T 19 12 3 L R M/C 3

FEATURES

- Welded with 100% CO2 and Ar+20-25% CO2 shielding gas
- Current: DC+
- Good arc stability
- Easy slag removal due to low carbon content
- Excellent resistance against granular corrosion
- High deposition rate and efficiency
- Suitable for flat and horizontal fillet positions

APPLICATIONS

- 18%Cr-12%Ni-2%Mo stainless steel
- Welding of dissimilar joints of stainless steels

CHEMICAL COMPOSITION

| | C | Si | Mn | P | S | Cr | Ni | Mo |
|---------------|------|------|------|------|------|------|------|-----|
| 100% CO2 | 0.03 | 0.50 | 1.50 | 0.02 | 0.01 | 17.8 | 11.8 | 2.7 |
| Ar+20-25% CO2 | 0.03 | 0.60 | 1.60 | 0.02 | 0.01 | 18.0 | 12.0 | 2.8 |

MECHANICAL PROPERTIES

| | TS MPa(Lbs/in ²) | EL (%) | Temp °C(°F) | CVN-impact value J(ft.lbs) | Ferrite number |
|---------------|---------------------------------|-----------|----------------|-------------------------------|----------------|
| 100% CO2 | 550(79,750) | 40 | -20 (4) | 50(37) | 8-10 |
| Ar+20-25% CO2 | 560(81,200) | 39 | -20 (4) | 45(33) | 8-10 |

DIAMETER/PACKAGING

| Diameter Mm (in) | Spool | Pac |
|---------------------|-----------------------|-------------|
| 1.2(0.045) | 5Kg 12.5Kg 15Kg | - - - |