

Technical data sheet <small>011121MBA</small>	Cored welding wire WA TUB SS R16L	
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CLASSIFICATION

ASME IIC SFA 5.22 / AWS A 5.22:	E316LT0-1 - E316LT0-4
EN ISO 17633-A:	T 19 12 3 L R C1 3 - T 19 12 3 L R M21 3
Equivalent Material number:	1.4430
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 8

DESCRIPTION

- Rutile flux cored stainless steel wire for gas shielded arc welding
- 19% chromium - 12% nickel – 2.5% molybdenum - low carbon deposit
- Exceptional resistance to moisture pick up
- Attractive bead appearance, automatic slag release, very good penetration and high productivity
- Excellent X-ray soundness
- Maximum performance in the horizontal and downhand positions
- Welded with CO₂ or classical economic Ar-CO₂ mixtures

APPLICATIONS

WA TUB SS R16L is suitable for welding stainless steels with an alloy content between 16 to 21% Cr, 6 to 13% Ni and up to 3% Mo, stabilised and unstabilised types. Service temperatures are typically -110°C to about 400°C.

Examples:

AISI	UNS	Material number	EN Symbol
316	S31600	1.4401	X5 CrNiMo 17-12-2
316L	S31603	1.4404	X2 CrNiMo 17-13-2
316LN	S31653	1.4406	X2 CrNiMoN 17-12-2
316Ti	S31635	1.4571	X6 CrNiMoTi 17-12-2
318	S31640	1.4583	X10CrNiMoNb 18-12

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	S	P
0.03	1.7	0.5	18.6	12.6	2.3	0.008	0.020

Typical ferrite level: 8 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
510	320	25	0°C: 32

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
560	420	40	0°C: 50

SHIELDING GAS

C1 (CO₂) or M21 (Ar + 15 - 25% CO₂) according to EN ISO 14175

OPERATING CONDITIONS

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out [mm]	Gas flow
1.2	DC+	140 - 250	23 - 33	15 - 25	15 - 25 l/min.
1.6	DC+	150 - 320	23 - 35	15 - 25	15 - 25 l/min.

WELDING POSITIONS

Flat, Horizontal

PACKAGING

Diameter	1.2 mm	1.6 mm
	EN ISO 544 – ASME II C SFA-5.2 M	
Spool type	BS300	
Weight	15 kg	

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.