Technical data sheet 011121MBA	Flux cored GTAW rod # WAROD 316L	Welding Alloys

CLASSIFICATION

ASME IIC SFA 5.22 / AWS A 5.22: R316LT1-5

DESCRIPTION AND APPLICATIONS

- WAROD 316L flux cored filler rod for TIG welding
- Produces slag to protect the reverse side of the root pass from oxidation by the atmosphere
- Saves the costs for back shielding gases
- Eliminates gas purging downtime, perfectly suited for stainless steel pipe welding
- Applicable from -196°C to +350°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	Si	Mn	Cr	Ni	Mo	Nb	Fe
0.03	0.50	0.90	18.50	12.00	2.8	-	Bal.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES (as per ASME II Part C SFA 5.22)

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	CVN [J]	
630	510	32	+20°C: 140 lateral expansion 2.0 mm	-196°C: 50 lateral expansion 0.65 mm

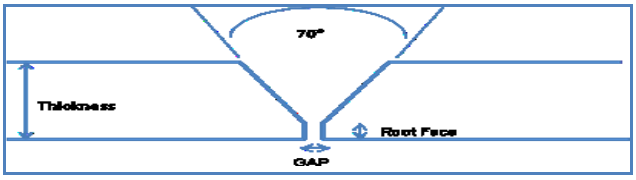
SHIELDING GAS

EN ISO 14175: I1 (100%Ar)

OPERATING CONDITIONS

Rod Ø x L [mm]	2.2 x 1000
Current [A]	80 - 140

Welding parameters depend on plate thickness. Typical weld preparation and welding parameters:



Thickness [mm]	GAP [mm]	Root face [mm]	Current [A]
3 - 5	2.0-4.0	1.0	80 – 95
5 – 10	2.0-4.0	1.0	90 – 110
10 -	2.0-4.0	1.0	105 - 140

WELDING POSITIONS

All positions

PACKAGING

Rod Ø x L [mm]	2.2 x 1000
Weight/box [kg]	5

Other packaging and other diameters: please consult us