


<b>Technical data sheet</b>  011121MBA	<b>Flux cored GTAW rod</b>  <b>WAROD 316L</b>	 <b>Welding Alloys</b>
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### 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 <sub>5</sub> [%]	CVN [J]	
630	510	32	+20°C: 140 lateral expansion 2.0 mm	-196°C: 50 lateral expansion 0.65 mm

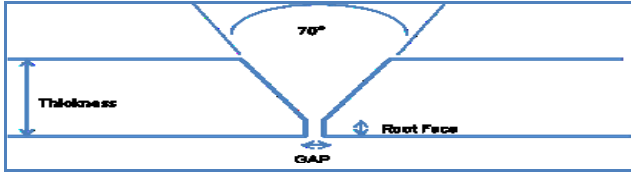
### SHIELDING GAS

EN ISO 14175: I1 (100%Ar)

### OPERATING CONDITIONS

<b>Rod Ø x L [mm]</b>	2.2 x 1000
<b>Current [A]</b>	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

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

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.