

## Cored Wires Stainless and Heat resistant steels

Fluxinox 316L is an alloyed rutile flux cored wire for the welding of unstabilized and stabilized corrosion resistant Cr Ni Mo-steels. The weld metal is resistant to intergranular corrosion up to 400 °C and non-scaling up to 800 °C. Fluxinox 316L exhibits outstanding, almost spatter-free, welding properties. Very easy slag removal from fillet welds, even in acute angles. The weld beads produced are finely rippled and without undercut. Due to only slight discoloration of the welds, pickling costs can be minimised.

Classification	
AWS	A5.22: E316LT0-4 / E316LT0-1
EN	12073: T 19 12 3 L R M 3 / T 19 12 3 L R C 3

Approvals	Grades
ABS	
BV	
DB	
DNV	
GL	
LRS	
TÜV	
UDT	

see Appendix, Classification Society Approvals, for details pag. 521

### Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
≤ 0.04	1.50	0.60	-	-	19	12	2.80	-	-	-	5-10

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) - 110 °C	Hardness
As Welded	≥ 320	≥ 510	≥ 30	≥ 32	-

Gas test: Acc. To EN 439: M21(Arcal 21-Atal 6)

**Shielding Gas:** Acc. To EN 439: M21(Arcal21-Atal6) or C1(Arcal 2)

### Materials

1.4401 (X4CrNiMo17-12-2), 1.4435 (X2CrNiMo18-14-3)  
 1.4571 (X6CrNiMoTi17-12-2), 1.4583 (X10CrNiMoNb18-12)  
 AISI 316L

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC+



**Packaging data:** K300 kg, 16

Diameters	1,0	1,2			
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