

FLUXINOX 316L-PF

Cored Wires Stainless and Heat resistant steels

Fluxinox 316L-PF is a rutile flux cored wire with a fast-freezing slag suitable for the welding of unstabilized and stabilized corrosion resistant CrNiMo steels. The weld metal is resistant to intergranular corrosion up to 400°C, and non-scaling up to 800°C. Fluxinox 316 L-PF exhibits outstanding, almost spatter-free, welding properties with very easy slag removal from fillet welds, even in acute angles. The weld beads produced are finely rippled without undercut. Due to only slight discoloration of the welds, pickling costs can be minimised. Due to its fast-freezing slag, Fluxinox 316 L-PF is used for welding in the horizontal (PD), overhead (PE) and vertical-up (PF) positions.

Classification	
AWS	A5.22: E316LT1-4 / E316LT1-1
EN	12073: T 19 12.3 L P M 1/ T 19 12.3 L P C 1

Approvals	Grades
LRS	
TÜV	

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 ²	Tensile Strength N/mm ²	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

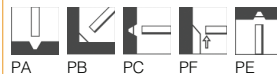
1.4401 (X4CrNiMo17-12-2), 1.4435 (X2CrNiMo18-14-3)
1.4571 (X6CrNiMoTi17-12-2), 1.4583 (X10CrNiMoNb18-12)
AISI 316L

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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