


Technical data sheet <small>011121MBA</small>	Cored welding wire TUBE S 316L-S	
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CLASSIFICATION

ASME IIC SFA 5.22 / AWS A 5.22:	EC316L
ASME IIC SFA 5.9 / AWS A 5.9:	EC316L
EN ISO 17633-A:	T 19 12 3 L M NO 3
Equivalent Material number:	1.4430
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 8

DESCRIPTION

- Cored stainless steel wire for submerged arc welding
- 19% chromium - 12% nickel - 3% molybdenum - low carbon deposit
- Attractive bead appearance without residual slag, outstanding slag release even in narrow gaps
- Mineral additions to the core improve mechanical strength and welding characteristics

APPLICATIONS

TUBE S 316L-S 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

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 WITH FLUX WAF 385

C	Mn	Si	Cr	Ni	Mo	S	P
0.02	1.40	0.60	19.5	12.0	2.80	0.008	0.020

Typical ferrite level: 10 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES WITH FLUX WAF 385

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
510	320	30	-100°C: 32

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES WITH FLUX WAF 385

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
610	450	35	-101°C: 50

FLUX DESCRIPTION

	WA FLUX 325	WA FLUX 385	WA FLUX 415	WA ULTRAFLUX
EN ISO 14174 class	S A AB 1 65	S A AF 2 64	S A FB 1 55	S A FB 1 55

PACKAGING

Diameter	1.6 mm - 3.2 mm
Standard packaging	EN ISO 544 - ASME IIC SFA-5.2 M Coil: B450
Weight	25 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.