



E316LT1-1/4

DESCRIPTION: E316LT1-1/4 is suitable for welding of 18%Cr-12%Ni-2%Mo steel(SUS 316) and extra-low carbon 18%Cr-12%Mo steel(SUS 316L). E316LT1-1/4 is a flux cored wire for Flat, H-Fillet and V-up position welding for CO₂ or 75%Ar-25%CO₂ shielding gas. It provides excellent usability with stable arc, less spattering, good bead appearance. For mechanized welding of H-Fillet this wire is an excellent choice, as it meets the requirement of superior wire feeding properties combined with high deposition efficiency.

APPROVAL: CWB(A5.22 E316LT1-1/4) & AWS A5.22 E316LT1-1/4

CHEMICAL COMPOSITION

CARBON	.028
SILICON	.60
MANGANESE	1.61
PHOSPHORUS	.012
SULFUR	.010
NICKEL	10.10
CHROMIUM	19.42

MECHANICAL PROPERTIES

Tensile Strength	
85,000 PSI	590 MPA
Yield Strength	
76,000 PSI	527 MPA
Elongation	
	42%

DEPOSITION WELDING

WELDING PROCEDURE

Wire diameter: 1.2mm

Amperage: 180~220A

Voltage: 30~32V

Current & polarity: DCEP

Shielding gas: CO₂100%, 20ℓ/min

Wire Stick-out: 20~ 25mm

Interpass temp: 150°C max.

Welding position: Flat

Welding speed: 300~400mm/min

Preheat temp: N/A

Root treatment: No

BUTT WELDING

WELDING PROCEDURE

Wire diameter: 1.2mm

Amperage: 180~220A

Voltage: 30~32V

Current & polarity: DCEP

Shielding gas: CO₂100%, 20ℓ/min

Wire Stick-out: 20 ~ 25mm

Interpass temp.: 150°C max.

Welding position: Flat

Welding speed: 300~ 400mm/min

Preheat temp: N/A

Root Treatment: No

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