



Cromacore DW 316L

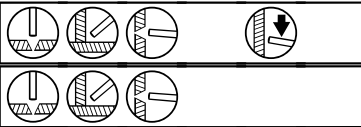
FCAW - Flux cored arc welding
Stainless Steel

Date: 2007-05-25
Revision: 13

Description:

Cromacore DW 316L is a rutile flux cored wire designed for welding the 19% Cr / 12% Ni / 3% Mo type stainless steels. Suitable also for related stabilised grades if service temperature is below 400°C. The wire operates with a very stable, spatter free arc producing a bright, smooth weld bead surface and self-releasing slag. Cromacore DW 316L is used mainly for downhand and horizontal-vertical welding and is ideal for standing fillets. Cromacore DW 316L, 0.9 mm is intended for use with material thicknesses less than 3.0 mm.

Welding positions:



Welding current:

DC+

Deposition efficiency:

87%

Shielding gas:

M21, 80% Ar + 20% CO₂, 22-25 l/min
C1, 100% CO₂, 22-25 l/min

Stick-out:

15-25 mm

Ferrite content:

FN 9

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min			0.5			17.0	11.0
Typical	0.03	0.7	1.2	0.025	0.009	18.3	12.1
Max	0.04	1.0	2.0	0.030	0.025	20.0	13.0

	Mo	Cu	V	Nb
Min	2.5			
Typical	2.8	0.11	0.1	0.08
Max	3.0	0.5	0.2	0.1

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, R _{p0.2} %:		410 MPa
Tensile Strength, R _m :	≥ 510 MPa	570 MPa
Elongation, A ₅ :	≥ 30%	44%
Impact energy, CV:		-20°C • 40 J

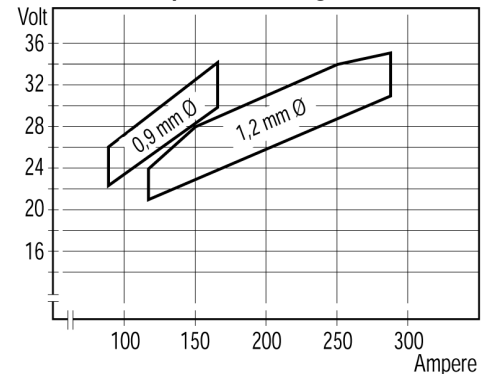
Classification:

AWS A5.22 E 316LT0-4/-1
ISO 17633-A T 19 12 3 L R M/C 3
Werkstoff no. 1.4430

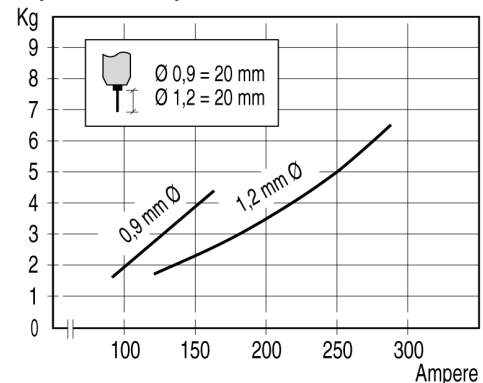
Approvals:

LR 316L S
DNV 316L
TÜV 07382.03
DB 43.042.09
GL 4571S
BV 316L
CE

Recommended parameter range:



Deposition rate per hour:



Product data:

Diam.mm	Product code	Spool weight
0,9	95712009	12,5 kg D300
1,2	95711012	15 kg BS300
1,2	95711112	5 kg BS200

Note

Strip:
S ≤ 0.03%
P ≤ 0.04%
N ≤ 0.06%

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