

SFC-316L

AWS A5.22 E316LT1-1
JIS Z3323 TS316L-FC1
EN ISO 17633-A T 19 12 3 L P C/M 2

FLUX CORED WIRES FOR STAINLESS STEEL

DESCRIPTION :

SFC-316L is a rutile flux cored tubular wire for all-positional welding using pure CO₂ or Argon CO₂ mixed shielding gas. It performs with smooth arc transfer, self-releasing slag, low spatter level, fine ripple and good intergranular corrosion resistance.

APPLICATIONS :

Suitable for welding 18%Cr-12%Ni-2% Mo stainless steels. Typical applications include corrosion resistance overlay, joining of type 316, 316L, CF-8M, and CF-3M stainless steels pipe and tube in chemical, oil and gas refineries.

NOTE ON USAGE :

1. Use DC (+) polarity.
2. Maintain a higher welding speed in order to get enough penetration in the down hand welding position.

WELDING POSITION:



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :(Shielding Gas: 100% CO₂)

Weld Metal Analysis :

Carbon (C)	0.028
Manganese (Mn)	1.56
Silicon (Si)	0.43
Phosphorus (P)	0.018
Sulphur (S)	0.012
Nickel (Ni)	12.03
Chromium (Cr)	17.83
Molybdenum (Mo)	2.59

TYPICAL MECHANICAL PROPERTIES OF WELD METAL:(Shielding Gas: 100% CO₂)

TS N/mm ²	572
EL%	40

TYPICAL IMPACT VALUES :

IV -196°C J	33
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APPROVALS :

ABS,BV,CCS,CE,DNV · GL,LR,JIS

SUGGESTED WELDING PARAMETERS (DC <+>)

Parameters	Diameter (mm)			
	1.2mm	1.6mm		
Welding Position	F, HF	V-UP, OH	F, HF	V-UP, OH
Voltage (Volt)	23 ~ 33	25 ~ 30	27 ~ 32	--
Current (Amp)	130 ~ 220	120 ~ 200	200 ~ 300	--