

80%Ar - 20%CO₂ / 100%CO₂
 EN ISO 17633-A T 19 12 3 L R C/M 3
 AWS A5.22 E316LT0-1/-4
 EN 1.4430

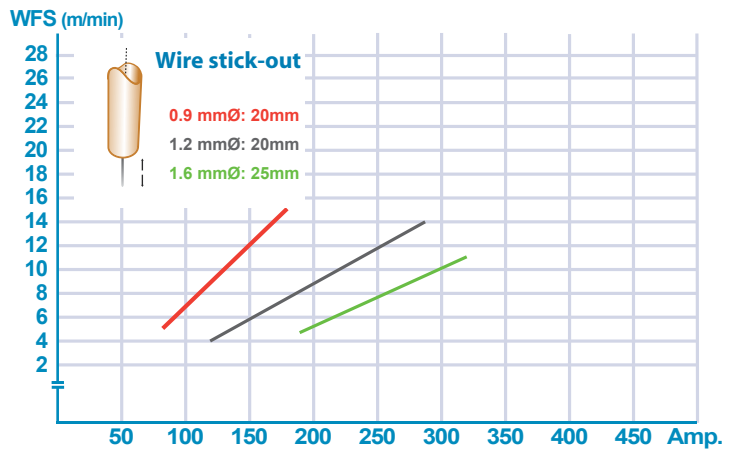
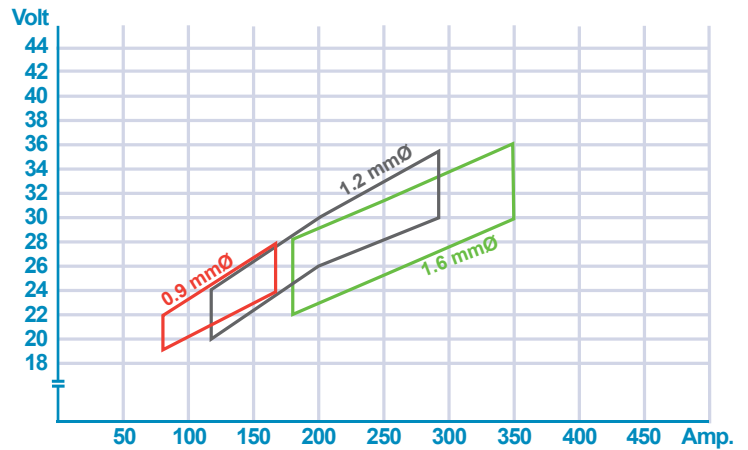
Description and Application

This is a rutile flux cored wire which operates with very stable, spatter free arcs producing bright, smooth weld bead surfaces and self releasing slag.

This wire is designed for welding 18%Cr-12%Ni-2.5%Mo stainless steels like type 316L or EN 1.4435. Due to the low carbon content in the weld metal, it is possible to obtain high resistance to intergranular corrosion.

PREMIARC™ DW-316L is used mainly for downhand and horizontal fillet welding.

Recommended Parameter Range, for flat position*



Typical Chemical Analysis (wt. %)*

C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.03	0.60	1.60	0.020	0.006	12.2	18.7	2.80	-	-	7.7	12.8	9.7

Typical Mechanical Properties*

	R _c (MPa)	R _m (MPa)	A ₅ (%)	CV (J)-20°C
	430	570	39	44
Guarantee	min.320	min.510	min.25	

* The above values and parameters are for all weld metal produced using Ar+CO₂ shielding gas

Welding Positions



Approvals

LR	DNV	BV	GL	ABS	R.M.R.S	Others
316L	316L	316L	4571S	MG	-	TÜV,DB,CWB

80%Ar - 20%CO₂ / 100%CO₂
 EN ISO 17633-A T 19 12 3 L P C/M 1
 AWS A5.22 E316LT1-1/-4
 EN 1.4430

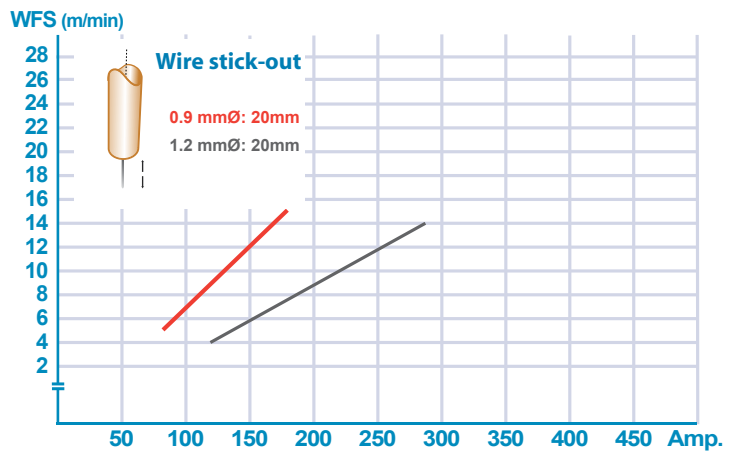
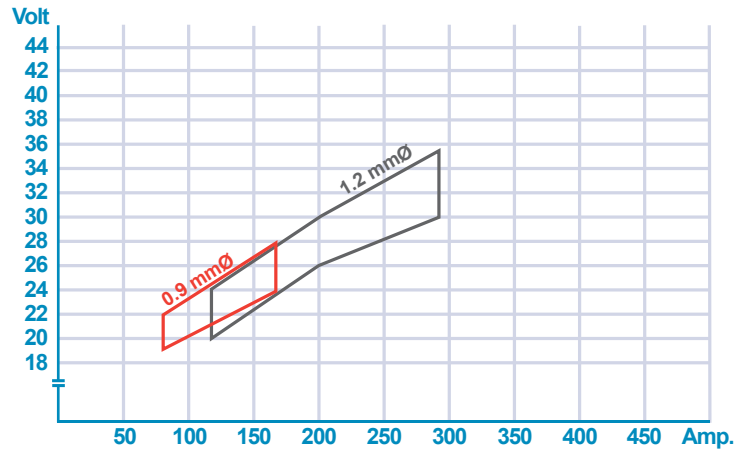
Description and Application

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PREMIARC™ DW-316LP is an all positional wire and is ideal for high productivity welding in the vertical up position.

Recommended Parameter Range, for flat position*



Typical Chemical Analysis (wt. %)*

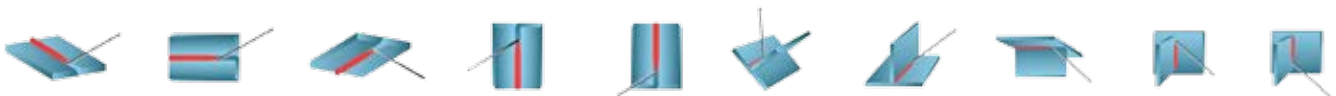
C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.03	0.70	1.40	0.019	0.006	12.3	18.4	2.90	-	-	7.0	11.5	7.8

Typical Mechanical Properties*

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV (J) -20°C
Guarantee	min.320	min.510	min.25	46

* The above values and parameters are for all weld metal produced using Ar+CO₂ shielding gas

Welding Positions



Approvals

LR	DNV	BV	GL	ABS	R.M.R.S	Others
316L	316L	316L	4571S	E316LT1-4	A-6	CWB,TÜV