

Description and Application

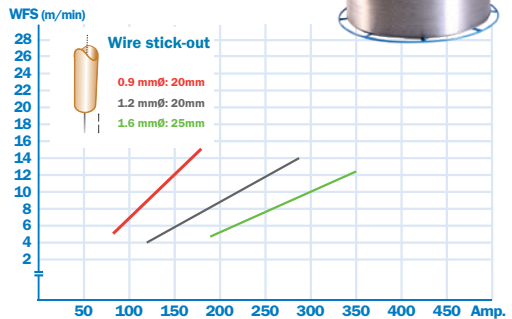
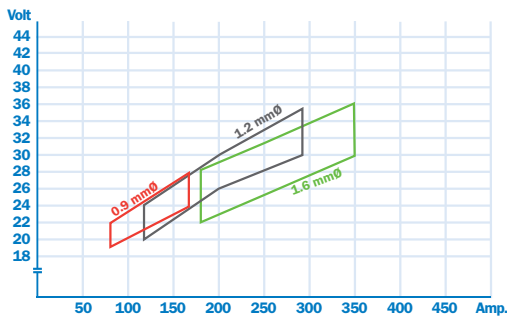
This is a rutile flux cored wire which operates with a very stable, spatter free arc producing bright, smooth weld bead surfaces and self releasing slag.

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.

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



Recommended Parameter Range, for flat position*



Typical Chemical Analysis (wt. %)*

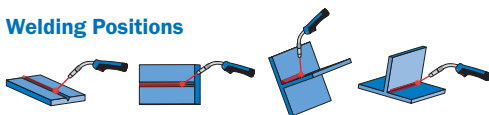
C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.03	0.60	1.60	0.020	0.006	12.2	18.7	2.80	-	-	7.7	12.8	9.7

Typical Mechanical Properties*

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)-20°C
Guaranty	min.320	min.510	min.25	44

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

Welding Positions



Approvals

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