

COREFIL 316LP

Flux cored wires [FCAW]

Stainless and high alloyed steels

| CLASSIFICATION: | APPROVALS: | APPLICATION: |
|--|------------|---|
| EN ISO 17633-A : T 19 12 3 L P M21 1 / EN ISO 17633-B: TS 316L-F M21 (C1) 1 DIN 8556 : 19 12 3 L AWS A-5.22 : E 316LT1-1/4 W.Nr. : 1.4430 | | Power generation industry Constructions & Engineering Petrochemical and chemical industry Shipbuilding&Offshore |

- Rutile flux cored wire for welding stainless steels of the 19% Cr - 12% Ni - 3% Mo type, Nb and Ti stabilized steels, provided that the working temperature does not exceed 400°C.
- Increased welding speeds, as well as the minimal cleaning and pickling requirements, provide significant time and cost savings.
- High resistance of the weld metal to intergranular corrosion in contact with liquids.
- Resistant to oxidation.
- Especially recommended for high-performance welding in all positions, including overhead and vertical-down.
- Very stable arc, self-removing slag.
- Light joint with very fine scale.

Base material



| DIN | W.Nr. | AISI/ASME | |
|--------------------|--------|-----------|------------------------|
| X5CrNiMo 17 12 2 | 1.4401 | 316 | 0H17N12M2T |
| X2CrNiMo 17 13 2 | 1.4404 | 316L | 00H17M14M2 |
| X5CrNiMoTi 17 12 2 | 1.4571 | 316Ti | H17N13M2T, H18N10MT |
| X2CrNiMoN 17 12 2 | 1.4406 | 316LN | H17N14M2 |
| X10CrNiMoNb 18 12 | 1.4583 | 318 | |
| X2CrNiMo 18 14 3 | 1.4435 | 316L (TP) | |
| X2CrNiMoN 17 13 3 | 1.4429 | | |
| X4CrNiMo 17 13 3 | 1.4436 | | |
| X6CrNiMoNb 17 12 2 | 1.4580 | 316CB | |
| X6CrNiNb 18 10 | 1.4550 | 347 (TP) | 0H18N12Nb |
| GX5CrNiNb 19 10 | 1.4552 | CF-8C | |
| GX2CrNiMo 19 11 2 | 1.4409 | | |
| GX5CrNiMo 19 11 | 1.4408 | CF-8M | |
| X10 CrNiMoTi18 12 | 1.4573 | 316Ti | |
| X5 CrNiMo17 13 | 1.4449 | 318 | |
| G-X5 CrNiMoNb18 10 | 1.4581 | 318 | |
| G-X6 CrNiMo18 12 | 1.4437 | | |
| G-X10 CrNiMo18 9 | 1.4410 | | |

Typical chemical composition %

| C | Si | Mn | Cr | Ni | Mo |
|------|------|------|-------|-------|------|
| 0,03 | 0,60 | 1,20 | 18,60 | 12,50 | 2,50 |

Typical mechanical properties

| | |
|---|-----|
| Yield strength Re [N/mm²] | 420 |
| Tensile strength Rm [N/mm²] | 560 |

| | |
|---|---|
| Elongation A5 [%] | 45 |
| Impact energy Kv [J] | 54J (0°C) / >32J (-196°C) / |
| Wire/rod type | rutile cored |
| Ferrite content | about 8 FN |
| Welding current |  |
| Welding positions |  |
| Additional description | Structure: Austenite + Ferrite |
| Shielding gases acc. to EN ISO 14175 | C1 - 100% CO2 / M21 - Ar + 15 - 25% CO2 / |

Welding parameters and packing

| ∅ | Welding current [A] | Voltage [V] | Gas flow | Weight of packet [kg] |
|-----|---------------------|-------------|----------|-----------------------|
| 1,2 | 130-280 | 21-34 | 20-25 | 15,0 |

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