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)	OH18N12Nb
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

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

METALWELD-FIPROM POLSKA spółka z o.o.

ul. Mikołajczyka 57, 41-200 Sosnowiec

+48 (32) 297 75 50 - 51

+48 (32) 297 75 88

export@metalweld.pl