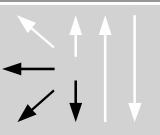


Classifications								
EN ISO 17633-A		EN ISO 17633-B			AWS A5.22 / SFA-5.22			
T 19 12 3 L R M21 (C1) 3		TS 316L-F M21 (C1) 0			E316LT0-4(1)			
Characteristics and typical fields of application								
<p>Rutile flux-cored wire of T 19 12 3 L R / E316LT0 type for welding of stainless steels such as 1.4435 / 316L. Easy handling and high deposition rate result in high productivity with excellent welding performance and very low spatter formation. Increased travel speeds as well as self-releasing slag with little demand for cleaning and pickling provide considerable savings in time and money. The wire shows good wetting behavior and results in a finely rippled surface pattern. The wide arc ensures even penetration and side-wall fusion to prevent lack of fusion. Suitable for service temperatures from -120°C to 400°C. The scaling temperature is approx. 850°C in air. For higher temperatures a niobium-stabilized consumable such as BÖHLER SAS 4-FD (FOXcore 318-T0) is required. For welding in vertical-up and overhead positions, BÖHLER EAS 4 M PW-FD (FOXcore 316L-T1) should be preferred.</p>								
Base materials								
<p>1.4401 X5CrNiMo17-12-2, 1.4404 X2CrNiMo17-12-2, 1.4409 GX2CrNiMo19-11-2, 1.4432 X2CrNiMo17-12-3, 1.4429 X2CrNiMoN17-12-3, 1.4435 X2CrNiMo18-14-3, 1.4436 X3CrNiMo17-12-3, 1.4571 X6CrNiMoTi17-12-2, 1.4580 X6CrNiMoNb17-12-2, 1.4583 X10CrNiMoNb18-12</p> <p>UNS S31600, S31603, S31635, S31640, S31653</p> <p>AISI 316L, 316Ti, 316Cb</p>								
Typical analysis of all-weld metal							Ferrite WRC-92	
	C	Si	Mn	Cr	Ni	Mo	FN	
wt.-%	0.03	0.7	1.5	19.0	12.0	2.7	3 – 10	
Mechanical properties of all-weld metal – typical values (minimum values)								
Condition	Yield strength $R_{p0.2}$		Tensile strength R_m		Elongation A ($L_0=5d_0$)		Impact work ISO-V KV J	
	MPa		MPa		%		20°C	-120°C
u	410 (≥ 320)		560 (≥ 510)		34 (≥ 30)		55	35 (≥ 32)
u	untreated, as-welded – Ar + 18 % CO ₂							
Operating data								
	Ø mm	Wire feed m/min	Arc length mm		Current A	Voltage V		
	1.2	5.0 – 15.0	~ 3		130 – 280	22 – 30		
	1.6	4.5 – 9.5	~ 3		200 – 350	25 – 30		
<p>Welding with standard GMAW power source with DC+ polarity. No pulsing needed. Backhand (drag) technique preferred with a work angle of approximately 80°. Ar + 15 – 25% CO₂ as shielding gas offers the best weldability. 100% CO₂ can be also used, but the voltage should be increased by 2 V. Suitable gas flow rate for welding outdoors is 18 – 25 l/min. The heat input should not exceed 2.0 kJ/mm, the interpass temperature be limited to max. 150°C and the wire stick-out 15 – 20 mm. Post-weld heat treatment generally not needed. In special cases, solution annealing can be performed at 1050°C followed by water quenching.</p>								
Approvals								
TÜV (05349), DB (43.014.15), DNV GL, LR (M21), CE								