

Cor-A-Rosta[®] 316L

CLASSIFICATION

AWS A5.22	E316LT0-1/ -4	A-Nr	8	Mat-Nr	1.4430
ISO 17633-A	T 19 12 3 L R C/M 3	F-Nr	6		
		9606 FM	5		

GENERAL DESCRIPTION

Gas shielded flux cored stainless steel wire electrode for downhand welding
 Stable arc, low spatter and good slag removal
 Excellent wire feeding and operator appeal
 Bright appearance of weld metal

WELDING POSITIONS (ISO/ASME)



PA/1G PB/2F PC/2G

CURRENT TYPE / SHIELDING GAS (ISO 14175)

DC +
 M21 : Mixed gas Ar+ (>15-25%) CO₂
 C1 : Active gas 100% CO₂
 Flow rate: 15-25 l/min

APPROVALS

Shielding gas	LRS	TÜV
M21	+	+
C1	+	

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

Shielding gas	C	Mn	Si	Cr	Ni	Mo	FN (acc.WRC 1992)
M21 /C1	0.03	1.3	0.5	19	12	2.7	8

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength [N/mm ²]	Tensile strength [N/mm ²]	Elongation [%]	Impact ISO-V(J)	
						+20°C	-110°C
Required: AWS A5.22 ISO 17633-A			not required	min. 485	min. 30		
Typical values	M21/C1	AW	min. 320 440	min. 510 580	min. 25 38	70	40

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.2
15 kg spool S300	X

Cor-A-Rosta[®] 316L : rev. C-EN27-19/05/16

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EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	EN 10088-1/-2	EN 10213-4	Mat. Nr	ASTM/ACI A240/A312/A351	UNS
Extra low carbon [C <0.03%]					
	X2CrNiMo17-12-2		1.4404	(TP)316L CF-3M	S31603 J92800
	X2CrNiMo18-14-3		1.4435	(TP)316L	S31603
	X2CrNiMoN17-11-2		1.4406	(TP)316LN	S31653
	X2CrNiMoN17-13-3		1.4429		
Medium carbon [C >0.03%]					
	X4CrNiMo17-12-2		1.4401	(TP)316	S31600
	X4CrNiMo17-13-3		1.4436		
		G-X5CrNiMo19-11	1.4408	CF 8M	J92900
Ti-, Nb stabilized					
	X6CrNiMoTi17-12-2		1.4571	316Ti	S31635
	X6CrNiMoNb17-12-2		1.4580	316Cb	S31640
		G-X5CrNiNb19-10	1.4552	CF-8C	J92710

WELDING PARAMETERS, OPTIMUM FILL PASSES

Diameter (mm)	Welding positions	
	PA/1G	PB/2F
1.2	100-250A	100-250A

REMARKS/APPLICATION ADVICE

For positional welding, use Cor-A-Rosta P316L