

Cor-A-Rosta 316L

Stainless rutile cored wire

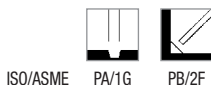
Classification

AWS A5.22-95 : E316LT0-1/ -4
EN 12073-99 : T 19 12 3 L R C/M 3

General description

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

Welding positions



Current type/Shielding gas

DC +
Ar+ (>5-25%) CO₂ (EN 439: M21)
100% CO₂ (EN 439: C1)
15-25 l/min

Approvals

Shielding gas	BV	DNV	LR	TÜV
M21	316L	316LMS	316L	+
C1	316L	316LMS	316L	

Chemical composition (w%) and Ferrite Number (FN), typical, all weld metal

Shielding gas	C	Mn	Si	Cr	Ni	Mo	FN
M21/C1	0.03	1.6	0.6	18.8	12.2	2.7	9

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
Required:	AWS A5.22-95 EN 12073-99		not required min. 320	min. 485 min. 510	min. 30 min. 25	
Typical values	M21/C1	AW	410	560	39	44

Packaging and available sizes

Unit	Net weight (kg)	Size (mm)
Plastic spool S300	12.5	X X

Cor-A-Rosta 316L: rev. EN 15

Cor-A-Rosta 316L

Materials to be welded

Steel grades	EN 10088-11-2	EN 102 13-4	W.Nr.	ASTM/ACI A240/A312/A351	UNS
Extra low carbon C<0.03%	X2 CrNiMo 17-12-2		1.4404	(TP)316L CF-3M	S31603 J92800
	X2 CrNiMo 18-14-3		1.4435	(TP)316L	S31603
	X2 CrNiMoN 17-11-2		1.4406	(TP)316LN	S31653
	X2 CrNiMoN 17-13-3		1.4429		
Medium carbon C >0.03%	X4 CrNiMo 17-12-2		1.4401	(TP)316	S31600
	X4 CrNiMo 17-13-3		1.4436		
Ti-, Nb- stabilized		GX5 CrNiMo 19-11	1.4408	CF 8M	J92900
	X6 CrNiMoTi 17-12-2		1.4571	316Ti	S31635
	X6 CrNiMoNb 17-12-2		1.4580	316Cb	S31640
	X6 CrNiNb 18-10		1.4550	(TP)347	S34700
		GX5 CrNiNb 19-10	1.4552	CF-8C	J92710

Welding parameters, optimum fill passes in shielding gas M21/C1

Welding position	PA/1G	PB/2F
Diameter (mm)	Current (A)	
1.2	100-250	100-250
1.6	140-300	140-300

Remarks/ Application advice

Use for positional welding: Cor-A-Rosta P316L