

HANKOOK WELDTEK CO.,LTD

31, Myeongnyesandan 1-ro, Jangan-eup,
Gijang-gun, Busan, Korea

TEL : 82-51-727-5588 FAX : 82-51-727-9160



WT-316LP

AWS A5.22 E316LT1-1/4

JIS Z3313 YF316LC

KS D3612 YF316LC

FOR STAINLESS
STEEL

Applications

WT-316L is suitable for welding of low carbon 18%Cr-12%Ni-2%Mo stainless steel..

Characteristics on Usage

- 1) This is a rutile type flux cored wire for all-position welding.
- 2) It provides the excellent usability with stable arc, less spattering, good bead appearance, better slag removal, and less quantity of welding fume comparable to solid wire.
- 3) Excellent weld ability and increased creep resistance at elevated temperature

Notes on Usage

- 1) Use 100% CO₂ gas or Ar+20~25% CO₂ gas.
- 2) The optimum flow of CO₂ for shielding is 20~25ℓ/min.
- 3) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.
- 4) Keep the distance between tip & base metal at 15~25mm.
- 5) For multi layer welding, keep preheat and inter-pass temperature below 150°C.

Typical chemical composition of all-weld-metal (%) (Shielding gas : CO₂)

	chemical composition(%)							
	C	Si	Mn	P	S	Cr	Ni	Mo
AWS	≤0.04	≤1.0	0.5~2.5	≤0.04	≤0.03	17~20	11~14	2~3
WT-316LP	0.02	0.7	1.3	0.018	0.005	19.1	12.2	2.2

Typical mechanical properties of all-weld-metal (Shielding gas : CO₂)

	Tensile strength (N/mm ²)	Elongation %	Impact value (J)	
			0°C	-18°C
AWS	≥485	≥30	-	-
WT-316LP	542	42	-	55

Size available and recommend welding parameters (DC+)

Dia		1.2(.045)	1.6(1/16)
Position	Current(A)		
Flat		180~260	200~280
Horizontal Fillet		180~260	200~280
Vertical up		140~220	160~240
Vertical down		140~220	160~240
Overhead		140~220	160~240

Welding positions



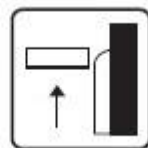
1G



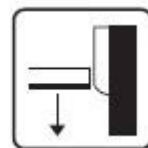
2F



3G



V-UP



V-DOWN



4G