

Stainless rutile cored wire

Classification

AWS A5.22 :E 316LT1-1/-4
ISO 17663 :T 19 12 3 L P C/M 2

General description

Gas shielded flux cored stainless steel wire 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 PF/3G up PE/4G

Current type / Shielding gases

DC +
Ar+(>5-25)% CO₂ (EN 439:M21)
100% CO₂ (EN439:C1)
15-25 l/min

Approvals

Shielding gases	DNV	GL	LR	
M21	316LMS	4571S	316L	+
C1	316LMS			

Typical chemical composition of all weld metal, (w%)

Shielding gases	C	Mn	Si	Cr	Ni	Mo	FN
M21/C1	0.03	1.3	0.6	18.3	12.5	2.8	9

Mechanical properties of all weld metal

	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact (ISO), J	
						+20°C	-20°C
Required	AWS A5.22 ISO 17663		not required min 320	min 485 min 510	min 30 min 25		
Typical values after welding	M21/C1	AW	415	560	41		45

Packaging, available sizes and identification

Unit type	Net weight/unit (kg)	Diameter (mm)
Plastic spool S200	5	X
Plastic spool S300	12.5	X

Identification Imprint: Cor-Revicod®308LT1

Cor-Revicod®308LT1: rev. EN 20

Cor-Revicod® 316LT1

Materials to be welded

Steel	EN 10088-11-2	EN 102 13-4	W.Nr.	ASTM/ACI A240/A312/A351	UNS
Low carbon steel C<0.03%	X2 CrNiMo 17-12-2		1.4404	(TP)316L CF-3M	S31603 J92800
	X2CrNiMo 18-14-3		1.4435	(TP)316L	S31603
Medium carbon steel C>0.03% Ti-, Nb- stabilized	X2 CrNiMoN 17-11-2		1.4406	(TP)316LN	S31653
	X2 CrNiMoN 17-13-3		1.4429		
	X4 C4rNiMo 17-12-2		1.4401	(TP)316	S31600
	X4 CrNiMo 17-13-3		1.4436		
	X6 CrNiMoTi 17-12-2		1.4408	CF 8M	J92900
	X6 CrNiMoNb 17-12-2		1.4571	316Ti	S31635
	X6 CrNiNb 18-10		1.4580	316Cb	S31640
		GX5 CrNiNb 19-10	1.4550	(TP)347	S34700
		GX5 CrNiNb 19-10	1.4552	CF-8C	J92710

Welding parameters, optimum fill, Shielding gases M21/C1

Diameter (mm)	Current / Voltage	Welding position				
		PA/1G	PB/2F	PC/2G	PF/3G up	PE/4G
1.2		100-250	100-250	100-200	100-200	

Remarks/ Application advice

Use for downhand welding Cor-Revicod® 316LT0.