

Stainless Steel Gas Shielded type FCW

KF316LAWS A5.22 E316LT1-1/4
JIS Z3323 TS316L-FC1**Product Features:**

- Rutile type gas shield flux cored arc welding wire, austenite structure weld metal.
- Smooth arc, low spatter loss and easy slag removal.
- High welding performance, weld metal contains adequate ferrite to get good crack resistance.
- Low carbon content in weld metal to get good inter-granular corrosion resistance.
- Good low temperature impact toughness and corrosion resistance.

Applications:

- Suitable for welding of severe acid and high heat resistance required SUS316 stainless steel.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Ni	Cr	Mo
0.03	0.50	1.45	12.4	18.9	2.35

Typical mechanical properties of all weld metal

Tensile Strength N/mm ²	Elongation %
550	42

Size (mm) & recommended welding parameters

Diameter		1.2mm	1.6mm
Polarity		DC+	DC+
Ampere (A)	Flat / Horizontal position	150~250	200~300
	Vertical / overhead position	90~130	----
Shielding Gas		CO ₂ / Mixed Gas	CO ₂ / Mixed Gas

Note:

- Use general CO₂ welding machine with proper feed roller pressure.

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