



## 316LT1-1

### Specifications / Certifications:

AWS A5.22 E316LT1-1/4

### Features

- Excellent usability with stable arc
- Less spattering
- Good bead appearance
- Better slag removal
- Less quantity of welding fumes comparable to solid wire.

### Applications

- Suitable for welding of low carbon stainless steel.

### Technical Specifications

- Use 100% CO<sub>2</sub> gas or Ar+20-25% CO<sub>2</sub> gas.
- The optimum flow of CO<sub>2</sub> for shielding is 20-25 l/min.
- Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 6.56 ft/sec (2m/sec) and more.
- Keep the distance between tip & base metal at 0.59-0.98 in (15-25 mm).
- For multi-layer welding, keep preheat and inter-pass temperature below 302°F (150°C)

#### Recommended GMAW Weld Parameters:

Flat	
Diameter	Amps
0.045"	180-260A
0.062"	200-280A
Horizontal Fillet	
Diameter	Amps
0.045"	180-260A
0.062"	200-280A
Vertical Up	
Diameter	Amps
0.045"	140-220A
0.062"	160-240A

#### Typical Chemical Composition:

Chemical	C	Mn	Si	P	S	Cr	Ni	Mo
<b>AWS</b>	0.04 max	0.5-2.5	1.0 max	0.04 max	0.03 max	17-20	11-14	2-3
<b>100% CO<sub>2</sub></b>	0.02	1.3	0.7	0.018	0.005	19.1	12.2	2.2
<b>Ar+20% CO<sub>2</sub></b>	0.03	1.33	0.72	0.018	0.005	19.32	12.15	2.3

#### Typical Mechanical Properties:

	Tensile Strength (psi)	Elongation	Impact Value (J)
<b>AWS</b>	70,343 min psi	30% min	
<b>100% CO<sub>2</sub></b>	78,610 psi	42%	55
<b>Ar+20% CO<sub>2</sub></b>	83,976 psi	44%	69

### Diameters & Packages

Diameter		Lbs	Pkg
0.035"	7/200"	10	Box
		25	Spool
		33	Spool
0.045"	3/64"	10	Box
		33	Spool
0.093"	3/32"	10	Box
0.125"	1/8"	10	Box

#### Welding positions



1G



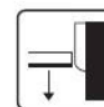
2F



3G



V-UP



V-DOWN



4G