

MIDALLOY MASTERCOR™ E316LT0-1/4 F & H FLUX-CORED WIRE

CLASSIFICATION

- AWS 5.22 Class E316LT0-1 and E316LT0-4 / ASME SFA 5.22 Class E316LT0-1 and E316LT0-4 flux cored wire.
- UNS# W31635 A# 8 F# 6

DESCRIPTION

- MIDALLOY Mastercor™ E316LT0-1/4 is a gas shielded flux-cored wire designed for flat and horizontal welding and can be used with 75% Argon 25% CO₂ or 100% CO₂ shielding gas.

APPLICATIONS

- MIDALLOY Mastercor™ E316LT0-1/4 is used for welding stainless steel grades such as ASTM A743 and A744, types CF-8M and CF-3M, and is used extensively in the pulp and paper processing industry, chemical processing equipment, furnace textile parts, and certain marine environments.
- MIDALLOY Mastercor™ E316LT0-1/4 has good toughness and is used for cryogenic service.
- MIDALLOY Mastercor™ E316LT0-1/4 can be used to overlay carbon steel. In this case, E316LT0-1/4 is generally used in the 2nd and 3rd layer and MIDALLOY E309LT0-1/4 is used in the 1st layer.

TYPICAL CHEMISTRY (%)

C	Mn	Si	Cr	Ni	Mo	P	S	N
0.03	1.3	.66	19.2	12.9	2.5	.03	.02	.05

Controlled Ferrite WRC 92: 5-15 FN

TYPICAL MECHANICAL PROPERTIES*

TENSILE STRENGTH	82,000 PSI
YIELD STRENGTH	63,000 PSI
ELONGATION IN 2"	40%
TOUGHNESS	100 ft lbs @ 72°F / 30 ft lbs @ -260°F

Note: Mechanical properties shown using 100% CO₂ shielding gas

OPTIMUM TYPICAL WELDING PARAMETERS (using 100% CO₂ shielding gas)

DIAMETER	AMPERAGE	VOLTAGE	WFS (IPM)	STICK/OUT
.045"	170-200	27-29	335-440	5/8" / 3/4"
1/16"	210-270	28-31	235-345	3/4" / 1"

Note: Lower volts by 2 volts when using 75AR/25CO₂

STANDARD PACKAGING

- 33 lb. spool

1/4/10

The contents of this publication are presented for informational purposes only, and while every effort has been made to ensure their accuracy, they are not to be construed as warranties or guarantees, express or implied, regarding the products or services described herein or their use or applicability. We reserve the right to modify or improve the designs or specifications of such products at any time without notice.

Office and Corporate Warehouse
 630 Axminister Drive
 St. Louis, MO 63026 • 636-349-6000 • 800-776-3300
 Fax 636-349-2240

