

MIDALLOY MASTERCOR™ E316LT1-1/4 AP FLUX-CORED WIRE

CLASSIFICATION

- AWS 5.22 Class E316LT1-1 and E316LT1-4 / ASME SFA 5.22 Class E316LT1-1 and E316LT1-4 flux cored wire.
- UNS# W31635 A# 8 F# 6

DESCRIPTION

- MIDALLOY Mastercor™ E316LT1-1/4 is a gas shielded flux-cored wire designed for all position welding and can be used with 75% Argon 25% CO₂ or 100% CO₂ shielding gas.

APPLICATIONS

- MIDALLOY Mastercor™ E316LT1-1/4 is used to weld type 316 stainless and other similar alloys, such as ASTM A723 and A744, types CF-8M and CF-3M. There are many applications for Midalloy E316LT1-1/4 flux cored wire in chemical and textile processing equipment, pulp and paper industries, and in various furnace parts and parts exposed to marine environments.

TYPICAL CHEMISTRY (%)

C	Mn	Si	Cr	Ni	Mo	P	S	Cu	N
0.03	1.10	.85	18.5	12.06	2.51	.02	.08	.08	.05

Controlled Ferrite WRC 92: 4-10 FN

TYPICAL MECHANICAL PROPERTIES*

TENSILE STRENGTH	81,000 PSI
YIELD STRENGTH	63,000 PSI
ELONGATION IN 2"	39%

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"	160-200	26-28	300-425	5/8" / 3/4"
1/16"	215-250	27-28	190-240	3/4" / 1"

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

STANDARD PACKAGING

- 33 lb. spool

2/16/09

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
 Fenton, MO 63026 • 636-349-6000 • 800-776-3300
 Fax 636-349-2240

