

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

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