

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

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