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% CO_2 or 100% CO_2 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% CO_2 shielding gas

OPTIMUM TYPICAL WELDING PARAMETERS (using 100% CO_2 shielding gas)

DIAMETER	AMPERAGE	VOLTAGE	WFS (IPM)	STICK/OUT
.045”	160-200	26-28	300-425	5/8” / ¾”
1/16”	215-250	27-28	190-240	¾” / 1”

Note: Lower volts by 2 volts when using 75AR/25CO_2

STANDARD PACKAGING

- 33 lb. spool

2/16/09

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