

**Standards**

TS EN ISO17633-A	: T Z 19 12 3 L P M21/C1 1
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AWSAS.22	: E316LT1-1/-4

**Chemical Composition of  
Weld Metal (Typical)**

C	Si	Mn	Cr	Ni	Mo
0.03	0.80	1.40	19.0	12.0	2.10

**Mechanical Properties - (Typical):** (With M21 gas)

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/-110°C)	Elongation (L <sub>0</sub> =5d <sub>0</sub> ) (%)
490	600	35 J	32

**Typical Base Material Grades**

- (1.4401) X5CrNiMo 17-12-2, (1.4404) X2CrNiMo 17-12-2, (1.4435) X2CrNiMo 18-14-3, (1.4436) X3 CrNiMo 17- 13-3, (1.4571) X6 CrNiMoTi 17-12-2, (1.4580) X6 CrNiMoNb 17-12-2, (1.4583) X10 CrNiMoNb 18-12, (1.4409) GX2 CrNiMo 19-11-2
- AISI 316 L, 316 Ti, 316 Cb

**Features and Applications**

- Rutile type, rapid hardening flux cored wire
- Weld metal microstructure is austenite (CrNiMo alloyed, 316 type)
- Used in welding of high carbon and stabilized 316 grade steels, low carbon 316 L grade stainless steels, food, pharmaceutical, chemical dye and machinery and equipment industries
- Weld metal has resisting between -110°C and 400°C service temperature
- Shielding Gas: CO<sub>2</sub> or M21

**Welding Positions**

**Current Type**

FCAW / D.C (+)

**Operating Data**

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
6011100257	1.20	0.047"	15	D 300

**Approvals:** ELOXCOR S 316 L (CO<sub>2</sub>): DNV-GL, SEPRO, CE