

BW-316LP

Stainless Steel FCAW Wire

For 18%Cr-12%Ni-2%Mo Stainless Steel


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Specification: AWS A5.22: E316LT1-1/4

Applications & Features:

BW-316LP is a rutile flux cored stainless steel wire for gas shielded welding. Suitable for the welding of low carbon 18% Cr-12%Ni-2%Mo stainless steel. Specifically designed for all positional welding.

Characteristics:

Provides excellent usability with stable arc, less spattering, good bead appearance, easy slag removal and less fume emission.

Superior mechanical properties.

Shielding gas is Argon+CO₂ or 100% CO₂.

Notes on Usage:

The optimum flow for shielding gas is 20-25l/min.

The distance between tip & base material is to be 15-25mm.

Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec & more.

Approvals:

CWB, ABS, BV, DNV, LR

Part Numbers:

P/N: 2114 (1.2mm 12.5kg spool)



Typical chemical composition of weld metal (%)

	C	Mn	Si	P	S	Cr	Ni	No	FN
BW-316LP	0.029	1.48	0.64	0.012	0.009	18.35	12.29	2.51	6

Typical mechanical properties of weld metal

	YP N/mm ² (MPa)	TS N/mm ² (MPa)	EL %	IV J (kgf-m)	
				0°C	-196°C
BW-316LP	425	594	41.1	52	-

Size & recommended current range (DC +)

Dia. mm (in)	Current(A)	Voltage(V)	Welding Speed(cm /min)
1.2(0.045)	150~300	24~33	20~60