

# GFC 316L



CLASSIFICATION : AWSA5.22 E316LT1-1/4 JIS Z3323YF316LC

## CHARACTERISTICS :

GFC-316L (for all-position operation) is low carbon 18%Cr-12%Ni-2%Mo austenitic stainless steel flux cored wire. The typical molybdenum gives improved resistance to pitting and crevice corrosion over grades 308L and 309L, particularly in the presence of chlorides. Manufactured under a quality system certified to ISO9001 requirements.

## TYPICAL WELD METAL ANALYSIS (%)

C	Mn	Si	P	S
0.030	1.61	0.40	0.026	0.015
Cr	Ni	Mo	Cu	
19.40	12.72	2.51	0.5 max	

## MECHANICAL PROPERTIES OF THE WELD METAL (RANGE)

Ult. Tensile Strength MPa	Elongation (%) (L=4D)
530	40

## TYPICAL APPLICATION :

Used for welding similar alloys (containing 2% molybdenum) such as AISI 316, 316L, 316Ti and 318; also for high temperature service applications. The presence of molybdenum provides increased creep resistance at elevated temperatures.

## Characteristics on Usage :

Generally used with 100% CO<sub>2</sub> shielding gas or mixtures of Ar + 20-25% CO<sub>2</sub>. Stable arc transfer and ideal slag removal guarantee that slag comes off easily, creating a smooth and fine bead surface.

RECOMMENDED CURRENT AND PACKING DATA :

Dia. mm	1.2	1.6
Current	F HF 140 ~ 240 23 ~ 33 V	200 ~ 300 27 ~ 32
Amp	V OH 120 ~ 200 27 ~ 32 V	-----

Package

Dia. mm	1.2 1.6
Spool kg	12.5 12.5