

FCW

Filler FCW-316LP

for Stainless Steel Flux Cored Wire

CLASSIFICATIONS: AWS A5.22 : E316LT1-1
 EN ISO 17633-A : T 19 12 3 L P C 1 1
 EN ISO 17633-B : TS 316L-F C 1 1
 JIS Z 3323 : TS316L-FC1

WELDING POSITIONS :



DESCRIPTION AND APPLICATIONS

Filler FCW-316LP is designed for 100% CO₂ gas shielding and all position welding. It performs with smooth arc transfer, low spatter level, fine ripple, fast freezing slag and good intergranular corrosion resistance.

Its typical applications include corrosion resistance overlay, joining of type 316 and 316L stainless steel pipe in chemical, oil and refineries.

TYPICAL ALL WELD METAL COMPOSITION (Wt%)

C	Mn	Si	Cr	Ni	Mo	Cu	S	P
0.027	1.40	0.55	18.50	12.30	2.60	0.03	0.011	0.010

- Shielding Gas: 100% CO₂

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES

YIELD STRESS	TENSILE STRENGTH	ELONGATION	CVN IMPACT VALUES
420 MPa	550 MPa	35%	35J @ -196°C

SIZES AND RECOMMENDED CURRENT RANGE (DC+)

DIAMETER Φ (mm)	VOLTAGE (V)	CURRENT (A)	SPOOL (KG)
0.8	17 - 25	50 - 140	5
1.0	19 - 31	70 - 170	12.5
1.2	22 - 36	120 - 220	12.5
1.6	26 - 38	200 - 300	12.5

- Use DC+ polarity and CO₂ as shielding gas.
- Gas flow rate 20 - 25 l/mm.