

NST A-316L

AWS: A5.22-95: E316LT 1-4
NS-EN ISO 17633-A: T 19 12 3 L P M1
EN ISO 9606-1: FM5



Flux cored wire for positional welding of corrosion resistant and stainless materials such as AISI 316, EN 1.4404 etc.

General description:

NST A-316L is a rutile flux cored wire for positional welding of corrosion resistant and stainless steel materials such as AISI 316 etc. The wire can be used with an Argon/CO₂ mixed shielding gas. This ensures a user friendly and stable welding arc, with less spatter, good visual bead appearance and smooth transition to the parent material. The newly developed slag system gives the welder better control of the weld pool and this wire can now be welded without weaving in all positions.

It is also suitable for use with ceramic backing for single sided welding. The flux cored wire can be used on Ti- and Nb-stabilized materials as long as the operating temperature does not exceed 400 °C.

Welding positions:



Welding current:

DC+

Shielding gas/Gas flow:

Argon+18-25% CO₂.
15-23 l/min.

Typical chemical composition of all-weld-metal:

C	Si	Mn	P	S	Cu	Ni	Cr	Mo	
0.024	0.51	1.37	0.022	0.005	0.10	11.40	19.25	2.61	

Ferrite content(Typical):

12,5% (DeLong).

Typical mechanical properties of all-weld-metal:

Yield and Tensile Strengths				
Yield Mpa(Rp0.2)	Tensile Mpa(Rm)	Elongation %		
436	580	42		

Guidance - Ampere (DC+):

Electrode diameter			
Ampere / Volt			

Packaging information:

0,9mm x 5,0kg D200
1,2mm x 5,0kg D200
1,2mm x 12,5kg D300

Approvals:

DNV, CE

Reference / date:

NST A-316L,
English, 27.06.2019.