CIGWELD

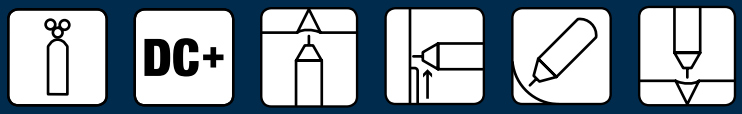
AN ESAB BRAND

FCAW

VERTI-COR 316LT

PRODUCT DATA SHEET

VERTI-COR STAINLESS STEEL FLUX CORED WIRES; 316LT- ALL POSITIONAL CAPABILITIES



VERTI-COR 316LT

- Vacuum Sealed in Aluminised Plastic Packs.
- Formulated for CO_2 or Argon + 18-25% CO_2 Shielding gases.
- High Deposition Rate Welding of Stainless Steels.

CLASSIFICATIONS:

AWS/ASME-SFA A5.22:	**E316LT1-1 (CO2) / E316LT1-4 (Ar + 18-25%CO_2).**

RECOMMENDED SHIELDING GAS:

AS 4882:	**ISO 14175 / AWS A5.32:**
SG-C	**C1**
SG-AC-18, or SG-AC-20	**M21**
Welding grade CO_2 or Ar+CO_2 (18-25%)	

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

	USING CO_2:	**ARGON + 18-25% CO_2:**
0.2% Proof Stress	**400 MPa**	**410 MPa**
Tensile Strength	**555 MPa**	**580 MPa**
Elongation	**42%**	**39%**

TYPICAL ALL WELD METAL ANALYSIS:

USING WELDING GRADE CO_2:			
C:	**0.03%**	Ni	**12.0%**
Mn:	**1.10%**	Mo:	**2.5%**
Si:	**0.60%**	P:	**0.024%**
Cr:	**18.8%**	S:	**0.002%**

CIGWELD Data Sheet **VERTI-COR 316LT V1-2023**
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DESCRIPTION AND APPLICATIONS:

Verti-Cor 316LT is a gas shielded stainless steel flux cored wire developed for positional welding applications on matching Molybdenum bearing 316 and 316L stainless steels. Verti-Cor 316LT is also suitable for the general purpose welding of other "300 series" austenitic stainless steels including 301, 302, 304 and 304L types.

The rutile type flux core gives smooth arc transfer characteristics and very low spatter levels with both CO_2 and Argon + 18-25% CO_2 shielding gases The fast freezing slag gives excellent weld pool control resulting in smooth mitre to slightly convex fillet welds in the flat, horizontal-vertical, vertical-up and overhead welding positions.

Actual weld metal mechanical properties achieved with Verti-Cor wires are influenced by many factors including base metal analysis/heat input used, shielding gas selection, number of weld passes and run placement etc.Please contact CIGWELD for welding procedure recommendations.

COMPARABLE CIGWELD PRODUCTS:

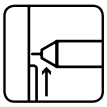
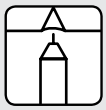
Autocraft 316LSi GMAW Wire	**AWS A5.9: ER316LSi**
Comweld 316L GAS/TIG rod	**AWS A5.9: ER316L**
Satincrome 316L -17 Electrode	**AWS A5.4: E316L -17**

PACKAGING DATA:

WIRE DIAMETER (MM)	TYPE	PACK WEIGHT	PACK PART NO.
1.2	Spool	15kg	722885

OPERATING DATA:

All welding conditions recommended below are for use with semi-automatic operation, DC electrode positive and welding grade CO_2 shielding gas with a flow rate of 15-20 litres/min.

WIRE DIAMETER (MM)	CURRENT RANGE (AMPS)	VOLTAGE RANGE (VOLTS)	CTWD	WELDING POSITION	
1.2	150-250	23-28	15-20		Flat
1.2	150-200	23-28	15-20		HV Fillet
1.2	120-180	22-27	15-20		Vertical up
1.2	140-180	22-27	15-20		Overhead

These machine settings are a guide only. Actual voltage, welding current and CTWD used will depend on machine characteristics, plate thickness, run size, shielding gas and operator technique etc.

P/N: 722885

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