

# ULTRA SS316LT1-1

## FLUX CORED WIRE

AWS A/SFA 5.22  
SS316LT1-1

### CLASSIFICATION:

- EN ISO 17633-A
- T 19 12 3 L R C/M 1
- TS316LT1-1
- AWS A/SFA 5.22
- SS316LT1-1

### TYPICAL APPLICATIONS:

- Pharmaceutical and food processing equipment
- Chemical storage tanks
- Pulp and paper industry
- Marine and offshore structures Heat exchangers Cryogenic applications

### KEY FEATURES:

- All position capability
- Radiographic quality weld Rutile type gas shielded FCW wire
- Easy slag removal, smooth weld bead
- Suitable for single and multi-pass welds
- Low fumes, Minimal spatters, High deposition

### TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL WT (%):

C – 0.03	Mn – 1.8	Si – 0.5	Cr – 18.5	Ni – 12.0	Mo - 2.5
----------	----------	----------	-----------	-----------	----------

### MECHANICAL PROPERTIES OF ALL WELD METAL:

Condition	UTS, Mpa	YS at 0.2% offset, Mpa	EL%	CVN Impact, J at
As Welded	560	400	30	20°C

### PARAMETERS & PACKING DATA:

Ø x L mm	Amperage, A
1.2	130-270
1.6	200-350

### DCEP(Electrode Positive)

Use 1-2 volts lower when using mix shielding gas

Available in Vacuum Pack of 15 kg wire layer wounded on Plastic Spool.



**Electrode Positive**

All positions except vertical down



Use 1-2 volts lower when using mix shielding gas