

AK E316LT1-1

Description: E316LT1-1 is a rutile type stainless steel flux cored wire, which can be welded in all positions. The welding process performance is excellent, the mechanical properties of the deposited metal are stable, and the heat resistance and corrosion resistance are excellent.

Application: Suitable for SUS316L steel, mostly used for welding urea, fertilizer, synthetic fiber, petrochemical or important structures of storage equipment, etc.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Cr	Mo	Cu
Requirement	0.04	1.00	0.50-2.50	0.03	0.04	11.0-14.0	18.0-20.5	2.0-3.0	0.75
Actual Result	0.036	0.55	1.21	0.004	0.03	11.98	18.55	2.32	0.31

Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥485	—	≥ 30	—
Actual Result	562	—	39	—

Recommended welding parameters:

Diameter/ mm	1.2	1.6		
Welding voltage/V	22-36	26-38	—	—
Welding current/A	120-260	200-300	—	—