CSF-316L(P)

For 18%Cr-12%Ni-2%Mo Stainless steel

AWS	A5.22	E316LT0(1)-1/-4
KS	D 3612	YF316LC
JIS	Z3323	TS316L-FB0(1)

Applications

CSF-316L(P) is suitable for welding of low carbon 18%Cr-12%Ni-2%Mo stainless steel.

Characteristics

(1) CSF-316L(P) is flux cored wire and designed for Fillet & H-F(All-position) welding with CO_2 gas Shielding.
(2) It provides the excellent usability with stable arc, less spattering, good bead appearance, better slag removal, and less quantity of welding fume comparable to solid wire.
(3) Is containing Ferrite of a reasonable quantity and crack-resistance, integranular corrosion resistance, mechanical properties of weld metal is superior.
(4) Shield gas is 100%CO_2 or Ar+CO_2 gas.

Notes on usage

(1) The optimum flow of CO_2 for Shielding is 20~25 ℓ /min.
(2) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.
(3) Keep the distance between tip & base metal at 15~25mm.

Typical chemical composition of weld metal (%)

(Shielding Gas : 100%CO_2)

	C	Mn	Si	P	S	Cr	Ni	No	FN
CSF-316L	0.03	1.45	0.60	0.019	0.012	18.5	12.4	2.20	8
CSF-316LP	0.03	1.20	0.60	0.020	0.008	18.6	12.5	2.50	7
CSF-316LP(Cryogenic)	0.03	1.25	0.50	0.020	0.008	18.4	12.8	2.30	6

Typical mechanical properties of weld metal

(Shielding Gas : 100%CO_2)

	YP N/mm²(MPa)	TS N/mm²(MPa)	EL %	IV (J)	
				0℃	-196℃
CSF-316L	425	565	43.0	55	-
CSF-316LP	420	560	45.0	54	-
CSF-316LP(Cryogenic)	425	560	44.0	57	35

Size & recommended current range (DC+)

Dia. mm (in)	Current(A)	Voltage(V)	Welding Speed(cm /min)
1.2(0.045)	150~300	24~33	20~60
1.6(0.062)	200~400	24~33	20~60

• Approval : CSF-316L : ABS, BV, DNV GL, KR, LR, NK / CSF-316LP(for cryogenic) : ABS, BV, DNV GL, LR