

# SFA 316L(P)

Stainless steel wires (FcaW)

## Description

SFA 316L(P) is flux cored wire and designed for Fillet & H-F(All-position) welding with CO2 gas Shielding. 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. It contains a reasonable quantity of Ferrite and crack-resistance, intergranular corrosion resistance, mechanical properties of weld metal is superior. Shield gas is 100%CO2 or Ar+CO2 gas. For 18%Cr-12%Ni-2%Mo Stainless Steel.

## Notes on usage

The optimum flow of CO2 for Shielding is 20~25ℓ/min. Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2 m/sec and more. Keep the distance between tip & base metal at 15~25mm.

## Applications

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

## Classification

AWS A5.22 E316LT0(1)-1/-4

KS D 3612 YF316LC

JIS Z3323 TS316L-FB0(1)

## Typical weld metal chemical composition (%) (Shielding Gas: 100%CO2)

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

## All weld metal mechanical properties (typical) (Shielding Gas : 100%CO2)

	Yield Strength N/mm2(MPa)	Tensile Strength N/mm2(MPa)	EL (%)	IV (J)	
				0°C	-196°C
SFA 316L	425	565	43.0	55	-
SFA 316LP	420	560	45.0	54	-
SFA 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