GWELD
SEAL OF TRUST

GFC 316L

IDENTIFICATION
GFC 316L, E316LT1-1/4

CLASSIFICATION
AWS A5.22 E316LT1-1/4, JIS Z3323 YF316LC

DESCRIPTION
GFC–316L (for all-position operation) is low carbon 18% Cr - 12% Ni - 2% Mo austenitic stainless steel flux cored wire. The typical molybdenum gives improved resistance to pitting and crevice corrosion over grades 308L and 309L, particularly in the presence of chlorides. Manufactured under a quality system certified to ISO:9001 requirements.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	P	S	Cr	Ni	Mo	Cu
0.04 max	0.5 - 1.5	1.0 max	0.030 max	0.030 max	17 - 20	Nov-14	02-Mar	0.5 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)
530 min	30 min

TYPICAL APPLICATIONS

Used for welding similar alloys (containing 2% molybdenum) such as AISI316, 316L, 316Ti and 318; also for high temperature service applications. The presence of molybdenum provides increased creep residence at elevated temperatures.

CHARACTERISTICS ON USAGE:

Generally used with 100% CO2 shielding gas or mixtures of Ar + 20-25% CO2. Stable arc transfer and ideal slag removal guarantee that slag comes off easily, creating a smooth and fine bead surface.

PACKING PARAMETERS

Size (mm)	Fillet (HF)		Voltage (OH)		Weight / Spool (kg)
	AMPS DC (+)	VOLTAGE (V)	AMPS DC (+)	VOLTAGE (V)	
1.2	140 - 240	23 - 33	120 - 200	27 - 32	12.5
1.6	200 - 300	27 - 32	Not Recommended		12.5