

# 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                |