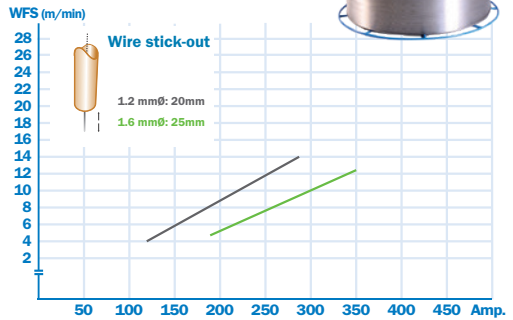
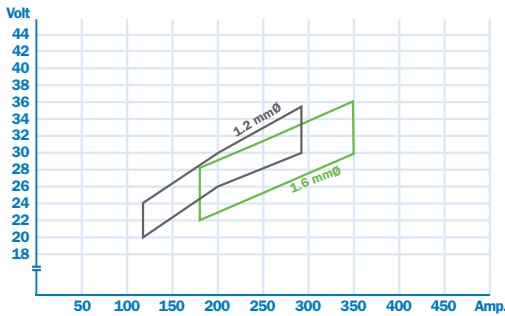


Description and Application

This wire is a rutile flux cored wire that operates with a very stable spatter free arc. **DW-316LH** is designed for welding 18%Cr-12%Ni-2.5%Mo stainless steels which will be applied for elevated temperatures.



Recommended Parameter Range, for flat position*



Typical Chemical Analysis (wt. %)*

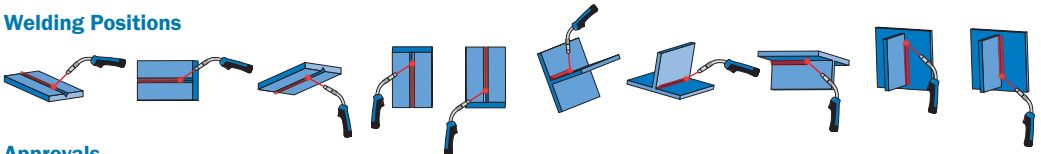
C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.03	0.54	1.28	0.020	0.011	11.9	18.9	2.45	-	-	8.1	12.2	9.4

Typical Mechanical Properties*

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)+20°C	CV(J)0°C
Guaranty	411	561	41	67	64
	min.320	min.520	min.3		

* The above values and parameters are for all weld metal produced using Ar+CO₂ shielding gas

Welding Positions



Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
-	-	-	-	-	-