



AWS      AWS A5.22 R316LT1-5 Z

JIS      3323 TS316L-R1

## Characteristics:

LFT-316L is a flux cored wire of stainless steel for TIG welding used on first layer for butt joint. It provides good bead soundness and does not need back shielding. These wires can also be used on multi-layers welding. It is austenitic stainless steel filler metal for welding of 18%Cr-12% Ni-2%Mo types. The molybdenum increased pitting corrosion resistance. The low carbon content improved intergranular corrosion.

## Notes on Usage:

1. For TIG process, use DC(-) current ,100%Ar shielding gas is recommended.
2. In order to have beautiful back bead appearance, the key hole formation during welding is necessary. The proper key hole size is recommended.
3. High pitch and little by little feeding of a filler rod is a must in order to melt it adequately.
4. 4. Keep the product dry, while it is stored or delivered.

## Typical chemical composition of weld metal (wt%)

C	Cr	Ni	Mn	Si	Mo
0.027	18.56	12.50	1.35	0.52	2.30

## Sizes and recommended current range ( DC - )

Plate Thickness (mm)	Root Gap (mm)	Current (A)
2-4	2.0	80-90
5-9	2.5	90-105
> 10	3.0	90-110