

FLUXINOX 316 L

Legovaný rúrkový drôt s rutílovou náplňou pre zváranie MAG

Alloyed rutile tubular cored electrode for MAG-welding

Wysokostopowy rutyłowy drut rdzeniowy o spawania MAG



Standards:

DIN EN 12073
AWS/ASME SFA-5.22
Comparable No. of Materials:

T 19 12 3 L R M 3 / T 19 12 3 L R C 3
E316LT0-4 / E316LT0-1
1.4430

SK Vlastnosti a oblasť použitia:

Legovaný rútkový drôt pre zváranie nestabilizovaných a stabilizovaných nehrdzavejúcich CrNiMo ocelí metódou MAG. Odolnosť proti rozpadu zrna do 400 °C, žiaruvzdorná do 800 °C. FLUXINOX 316 L sa vyznačuje temper bez rozstrekovým procesom zvárania. Troška je ľahko odstrániteľná i u kútových zvarov. Zvary sú ploché s bez vrubovými prechodmi do základného materiálu.

GB Applications and properties:

Alloyed rutile tubular cored electrode for welding of unstabilized and stabilized corrosion resistant Cr Ni Mo-steels. Weld metal is resistant to grain disintegration up to 400 °C, non-scaling up to 800 °C. Thanks to only little discoloration of the welds, pickling costs can be kept low.

POL Zastosowania i własności:

Wysokostopowy drut rutyłowy do spawania stabilizowanych i niestabilizowanych nierdzewnych stali Cr-Ni-Mo. Stopiwo jest odporne na rozpad ziarna przy roboczych temperaturach do 400°C, odporność na tworzenie zgorzeliny do około 800°C. Dzięki tylko nieznacznemu zabarwieniu spoiny można obniżyć koszt wytrawiania.

Materials for instance:

| Joining of alloy steels | | | |
|-------------------------|-----------------|------------------|--------------------|
| No. of Materials | EN-Designation | No. of Materials | EN-Designation |
| 1.4401 | X5CrNiMo17-12-2 | 1.4571 | X 6CrNiMoTi17-12-2 |

Approvals:

TÜV, TÜV Austria, DB, ABS, BV, DNV, GL, LRS

Analysis of all-weld metal (typical value sin %):

| C | Si | Mn | Cr | Ni | Mo | Ferrite |
|-------|------|------|-------|-------|------|---------|
| ≤0,04 | 0,60 | 1,50 | 19,00 | 12,00 | 2,80 | 5-10 |

Mechanical properties of all-weld metal (single values are typical values):

| Heat treatment | 0,2 % Proof stress [N/mm ²] | Tensile strength [N/mm ²] | Elongation A ₅ [%] | Impact energy ISO-V [Joule] | |
|----------------|---|---|----------------------------------|-----------------------------|---------|
| | | | | +20 °C | -110 °C |
| AW | ≥320 | ≥510 | ≥30 | ≥47 | ≥32 |

AW = as-welded

Chemical composition and mechanical properties apply to the use of shielding gas:

DIN EN 439 - M21 (82 Vol. % Ar + 18 Vol. % CO₂)

Shielding gas as to DIN EN 439:

M21 (ARCAL 21), C1 (carbon dioxide)

Consumption:

12–15 l/min for $\varnothing \leq 1,6$ mm

Form of delivery:

| Wire cage reel K300 (15 kg) | | |
|-----------------------------|-----|-----|
| Wire diameter [mm] | 1,0 | 1,2 |

Further forms of delivery on request.

Type of current/Polarity/Welding positions:

