

MAXFIL-316L

Stainless Steel Flux Cored Wire

CODIFICATION:

AWS/SFA 5.22

E316LT1-1

CHARACTERISTICS AND APPLICATIONS:

Maxfil-316L is an all position stainless steel flux cored wire designed for optimum performance with 100% CO₂ gas shielding. This wire is designed with fast freezing slag characteristics and good slag detachability. The wire welds satisfactorily in out of position and performs equally well when welding in the flat & horizontal position. The weld metal is of radiographic quality, and to obtain resistance to intergranular corrosion due to carbon precipitation without the use of stabilizers.

Maxfil-316L is designed for welding of low carbon similar composition steels like 316L type and their equivalents with excellent weld ability.

CHEMICAL COMPOSITION OF ALL WELD METAL (%):

ELEMENTS	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
RANGE	0.040	0.5-2.5	1.0	0.030	0.040	17.0-20.0	11.0-14.0	2.0-3.0	0.75
TYPICAL	0.025	1.25	0.70	0.006	0.025	18.90	11.88	2.80	0.020

MECHANICAL PROPERTIES OF ALL WELD METAL:

Property	UTS (Mpa)	%El (L=4d)
Range	485 Min	30 Min
As Welded	555	35

WELDING POSITIONS: H, F, VU, OH

WELDING PARAMETER: DC (+)

Diameter (mm)	HORIZONTAL/FLAT		VERTICAL UP		OVER HEAD	
	Volt, V	Current, A	Volt, V	Current, A	Volt, V	Current, A
1.20	24-30	160-260	20-22	100-160	22-25	100-160
1.60	24-30	180-300	20-22	110-200	22-25	110-200

SHIELDING GAS : Carbon Dioxide CO₂ (100%) at flow rate 12-15 litres per minute.

PACKING :

Standard size : 1.20 & 1.60mm.

Quantity : Supplied approximately 12.5/15Kgs in a plastic spool. Each spool is sealed in an airtight polythene bag and then packed in a corrugated box.

AUTHORISED DISTRIBUTOR - SALES & SERVICE

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