

MIG/MAG Cored Wires Stainless and Heat resistant steels

FLUXINOX 316L-PF is a rutile flux cored wire with a fast-freezing slag suitable for the welding of unstabilized and stabilized corrosion resistant CrNiMo steels. The weld metal is resistant to intergranular corrosion up to 400°C, and non-scaling up to 800°C. FLUXINOX 316 L-PF exhibits outstanding, almost spatter-free, welding properties with very easy slag removal from fillet welds, even in acute angles. The weld beads produced are finely rippled without undercut. Due to only slight discolouration of the welds, pickling costs can be minimised. Due to its fast-freezing slag, FLUXINOX 316 L-PF is used for welding in the horizontal (PD), overhead (PE) and vertical-up (PF) positions.

Classification	
EN ISO	17633-A: T 19 12 3 L P C 1
EN ISO	17633-A:T 19 12 3 L P M 1
EN ISO	17633-B: TS316L-FB1
AWS	A5.22: E316LT1-1
AWS	A5.22: E316LT1-4

Approvals	Grade
DB	●
DNV	316L
LRS	316L S
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	Cr	Ni	Mo	Ferrite
≤ 0.04	1.4	0.6	19	12	2.8	5-10

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				20 °C	-110 °C
As Welded	≥ 320	≥ 510	≥ 30	≥ 47	≥ 27

Gas test: 82% Ar+18% CO2

Shielding Gas - EN ISO 14175 : C1, M21

Materials

1.4401 (X4CrNiMo17-12-2), 1.4435 (X2CrNiMo18-14-3)

AISI 316L

1.4571 (X6CrNiMoTi17-12-2), 1.4583 (X10CrNiMoNb18-12)

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data

Packaging Type	BS300	S200
Diam(mm) / weight(kg)	15	5
1.0	●	
1.2	●	●