



# CROMACORE® 316LT1

FCAW - Flux cored arc welding  
Stainless Steel

Date:	2023-09-21
Revision:	4

### Description:

Cromacore 316LT1 is a rutile flux cored wire intended for welding the 19% Cr / 12% Ni / 3% Mo type stainless steels. The wire has been specially designed for fully positional welding at high welding currents. Suitable also for related stabilised grades if service temperature is below 400°C. Cromacore 316LT1 operates with a very stable, spatter free arc and produces a bright, smooth weld bead surface and self-releasing slag. Ideal for high productivity welding in the vertical position.

### Welding positions:



### Welding current:

DC+

### Deposition efficiency:

87%

### Shielding gas:

M21, 80% Ar + 20% CO<sub>2</sub>, 20-25 l/min

### Stick-out:

15-20 mm

### Ferrite content:

FN 9

### Chemical composition, wt. %

	C	Si	Mn	P	S	Cr	Ni
Min			0,5			17,0	11,0
Typical	0,026	0,68	1,40	0,027	0,010	18,95	12,52
Max	0,04	1,0	2,0	0,030	0,025	20,0	13,0

	Mo	Cu
Min	2,50	
Typical	2,80	
Max	3,00	0,5

### Mechanical properties

	Specified	Typical
Yield strength, Rp0.2%:		497 MPa
Tensile Strength, Rm:	≥ 510 MPa	656 MPa
Elongation, A5	≥ 30%	36%
Impact energy, CV:		-20°C • 52 J
		-110°C • 37 J
		-196°C • 28 J

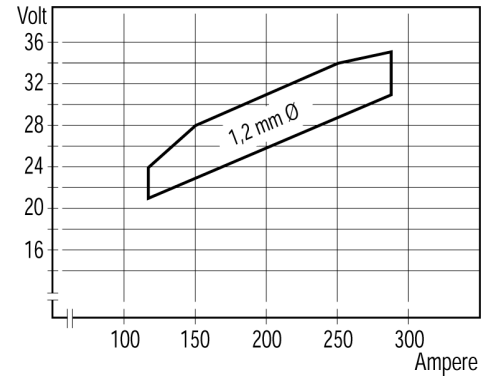
### Classification:

AWS A5.22 E 316LT1-4  
ISO 17633-A T 19 12 3 L P M 1

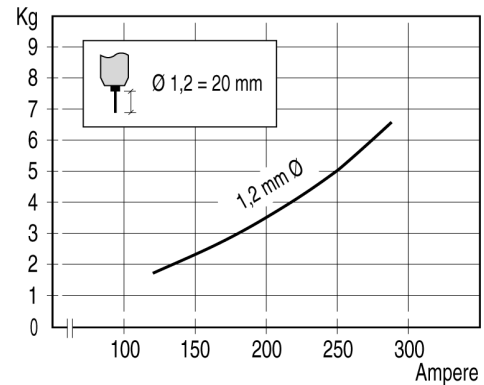
### Approvals:

CE  
TÜV

### Recommended parameter range:



### Deposition rate per hour:



### Product data:

Diam.mm	Product code	Spool weight
1,2	94741012	15 kg BS300

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