Inweld 316LT-1 AP

AWS A5.22 E316LTo-1

Chemical Composition of Inweld 316LT-1 AP

C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu	Fe
0.04	17.0-20.0	11.0-14.0	2.0-3.0	0.5-2.5	1.0	0.04	0.03	---	0.5	Balance

Single values are maximum unless otherwise specified.

Description and Applications

The composition of this weld metal is the same as E316To-1 electrodes, except for the lower carbon content. By specifying the low carbon in this alloy, it is possible to obtain resistance to intergranular corrosion due to carbide precipitation without the use of stabilizers such as columbium (niobium) or titanium. This low-carbon alloy, however, is not as strong at elevated temperatures as the columbium (niobium)-stabilized alloys.

The AP version of this meterial allows for flux that provides the ability to weld in any position. The composition of the weld material is the same.

Procedure

Typical Weld Metal Properties

	AWS Spec (ksi)
Average As-Welded Hardness:	
Tensile Strength:	70,000
Yield Strength:	
Elongation:	30%

Recommended Parameters

FCAW - DCEP, CO_2 Shielding Gas

Wire Diameter	Voltage	Amperage