



# Shield-Bright 316L Xtra

FCAW

Shield-Bright 316L Xtra is designed for welding of 316 type of materials and specifically for applications where the service environment can produce pitting corrosion in the flat and horizontal position. Commonly used in the pulp and paper industry. Weld beads are finely rippled and horizontal fillets have an essentially flat contour surface with equal leg length. Either pure CO<sub>2</sub> or mixed gas (75% Argon/25% CO<sub>2</sub>) can be used.

## Welding Current

DC (+)

## Shielding Gas

CO<sub>2</sub> or 75% Argon/25% CO<sub>2</sub>

PACKING/ORDERING INFORMATION			
Part Number	Dia (mm)	Carton Weight (kg)	Pallet Weight (kg)
VacPac			
35FX12248V	1.2	12.5	787.5
35FX16248V	1.6	12.5	787.5

CLASSIFICATIONS	APPROVALS		TYPICAL ALL WELD METAL COMPOSITION (%)			TYPICAL MECH. PROPERTIES ALL WELD METAL			
			Gas	CO <sub>2</sub>	75%Ar/25%CO <sub>2</sub>		As Welded CO <sub>2</sub>	As Welded 75%Ar/25%CO <sub>2</sub>	
<u>SFA/AWS A5.22</u> E316LT0-1/E316LT0-4 <u>EN 12073</u> T19 12 3 L R C 3 T19 12 3 L R M 3	ABS	E316LT0-1				Yield Stress, Mpa			
	DNV	316L	C	0.030	0.030				
	KR	RW316LG	Mn	1.5	1.6		Tensile Strength, MPa	411	415
		LR	316L	Si	0.6	0.7	Elongation, %	565	571
				Cr	18.8	19.0	Charpy V	Test Temp, °C	Impact Values*
				Ni	12.0	12.0			
				Mo	2.5	2.6			
			FN	7.5	9				

