



MODI FC 316 LT FOR STAINLESS STEEL

CLASSIFICATION : AWS/A 5.22 : E 316L T1-1/-4

TYPICAL APPLICATIONS : Modi FC 316LT is designed for MAG welding of low carbon 18% Cr - 12% Ni - 2% Mo stainless steels. This wire has low carbon content which gives good resistance to most types of corrosion of the weld metal (AISI 316L, 316 Ti, 316 Cb)

CHARACTERISTICS :

1. Modi FC 316LT is a titania type of flux cored wire for all position welding.
2. The wire has self-detaching slag, spray-like arc transfer, excellent weldability and increased creep resistance at elevated temperature.
3. The weld metal contains optimum ferrite contents in the austenitic structures. Therefore their weldability is excellent with lower crack susceptibility.
4. The shielding gas should be used 100% CO₂ and 80% Ar + 20% CO₂ for welding.

CHEMICAL COMPOSITION OF ALL WELD-METAL(%) :

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.040	0.5-2.5	1.0	0.03	0.04	17.0-20.0	11.0-14.0	2.0-3.0	0.5
max		max	max	max				max

MECHANICAL PROPERTIES OF ALL WELD METAL :

Ultimate Tensile	Elongation
Strength (min)	(%)
N/mm ² (Kg/mm ²)	(min)
490(50)	30

CURRENT CONDITIONS : Use DC (+)

SIZE (mm) : 1.2 1.6

AMPS : 100-240 160-260



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