

Stainless Steel Gas Shielded type FCW

GMX316LF

AWS A5.22 E316LT0-1/4
A5.22M E316LT0-1/4
JIS Z 3323 TS316L-FB0
ISO 17633-A-T 19 12 3 L P C1 3, M21 3

Product Features:

- GMX316LF is especially developed for flat, high deposition welding.
- The smooth weld metal transfer and easy slag removal eliminates unnecessary clean up.
- The weld bead is uniform, flat to slightly convex and free from porosity.
- Penetration is complete and easy to obtain the flat equal weld leg.
- For welding types of 301, 302, 304, 304L, 305, 308L, 316L steel.
- The content of lower carbon helps minimize carbide precipitation and obtain more resistance to inter-granular corrosion.

Applications:

- Use general CO₂ welding machine, but loosen the wire-feeding roller.
- This wire is formulated for using Argon plus CO₂ gas shielded or straight CO₂ gas. However, the Ar/CO₂ mixture gas will produce a smoother arc with less spatter and slight higher yield and tensile strength.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Ni	Cr	Mo	S	P
0.03	0.60	1.4	12.1	18.2	2.70	≤ 0.03	≤ 0.03

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %
461	583	40

Size (mm) & recommended welding parameters

Diameter		1.2mm	1.6mm
Polarity		DCRP	DCRP
Ampere (A)	Flat position	160~220	220~300
Voltage (V)	Flat position	22~31	24~32
Shielding Gas		CO ₂ / Mixed Gas	CO ₂ / Mixed Gas

Note:

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