

Stainless Steel Gas Shielded type FCW

GMX316L

AWS A5.22 E316LT1-1/4
A5.22M E316LT1-1/4
JIS Z 3323 TS316L-FC1, FM1
ISO 17633-A-T 19 12 3 L P C1 1, M21 1

Product Features:

- GMX316L is especially developed for out-of-position welding.
- The smooth weld metal transfer and easy slag removal eliminates unnecessary clean up.
- The weld bead is uniform, flat to slightly concave 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 | 12.2 | 18.3 | 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 | 42 |

Size (mm) & recommended welding parameters

| Diameter | | 1.2mm | 1.6mm |
|---------------|----------------------|-----------------------------|-----------------------------|
| Polarity | | DCRP | DCRP |
| Ampere (A) | Flat position | 160~220 | 220~300 |
| | Vertical up position | 90~130 | ---- |
| Voltage (V) | Flat position | 22~30 | 24~32 |
| | Vertical up position | 22~25 | ---- |
| Shielding Gas | | CO ₂ / Mixed Gas | CO ₂ / Mixed Gas |

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