



Stainless Steel Flux Cored Wire



Code & Specification

ASME SFA/AWS A5.22 E316LT1-1 (CO₂) E316LT-4 (Argon +20-25% CO₂)

Description

BLUME® E316LT1-1/4 is a stainless steel flux cored wire with all positional capabilities. Vacuum sealed in aluminised plastic packs. Formulated for CO₂ or Argon +20-25% CO₂ shielding gases. High deposition rate welding of stainless steel. Welds well in all positions. Excellent welder appeal. Provides a low spatter hence requiring less clean-up. Good weld soundness and extended shelf-life. Fast freezing and self detaching slag. Provides spray-like arc transfer and high moisture resistance.

Applications

Used for joining and cladding of Type 316, 316L, CF-3M and CF-8M stainless steel.

Mechanical Properties

	As-welded (Argon +20-25% CO ₂)	As-welded (CO ₂)
Yield Strength, MPa	405	415
Tensile Strength, MPa	580	555
Elongation, %(L=4d)	35	39

Undiluted Weld Metal Analysis (wt%)

		Using CO ₂		
C	Mn	Si	Cr	Ni
≥ 0.03	1.00 - 2.00	0.60 - 0.80	18.0 - 19.0	12.0 - 13.0
P	S	Mo		
≤ 0.03	≤ 0.03	2.50 - 2.80		

Suggested Welding Parameters (DC+)

Diameter	Flat		Vertical-up		Overhead	
	Volts	Amps	Volts	Amps	Volts	Amps
1.2mm (.045")	23 - 28	150 - 250	22 - 27	120 - 180	22 - 27	140 - 180

Packaging

15 kgs (33 lbs) [Net Weight] Plastic spools with OD = 270mm (11")

Approvals



Blumenotics Pvt. Limited

An ISO 9001:2015 Company

3rd Floor, No. 23, 5th Cross, Koramangala 5th Block, Bangalore 560 095, India
Tel: +91 80 2528 3432 Email: info@blumenotics.com Web: www.blumenotics.com

BLUME & BLUME Logo are registered trademark of Blumenotics Pvt. Limited