

CLEARINOX F 316L PF

TOP FEATURES

- Reduced welders' exposure to welding fumes.
- High alloyed rutile flux cored wire with fast freezing slag for the welding of 316 corrosion resistant Cr-Ni-Mo steels.
- Reduced welding fume (up to -40%).
- Reduced emission of hexavalent Cr content (up to -60%).
- Easy slag removal.

CLASSIFICATION

| | |
|----------------|-------------------|
| AWS A 5.22 | E316LT1-1 |
| EN ISO 17633-A | T 19 12 3 L P C 1 |
| EN ISO 17633-B | TS316L-FB1 |

CURRENT TYPE

DC+

WELDING POSITIONS

All positions

SHIELDING GASES (ACC. EN ISO 14175)

| | |
|-----|---------------------------------------|
| C1 | Active gas 100% CO ₂ |
| M21 | Mixed gas Ar+ >15-25% CO ₂ |

APPROVALS

| LR | BV | DNV | TÜV | DB |
|----|----|-----|-----|----|
| + | + | + | + | + |

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

| C | Mn | Si | Cr | Ni | Mo | Ferrite |
|-------|-----|-----|----|----|-----|---------|
| ≤0.04 | 1.4 | 0.6 | 19 | 12 | 2.8 | 5-10 |

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

| | Shielding gas | Condition* | Yield strength (MPa) | Tensile strength (MPa) | Elongation (%) | Impact ISO-V (J) | |
|----------------|---------------|------------|----------------------|------------------------|----------------|------------------|--------|
| | | | | | | 20°C | -110°C |
| Typical values | M21 | AW | ≥320 | ≥510 | ≥30 | ≥47 | ≥27 |

* AW = As welded

Gas test: 82% Ar + 18% CO₂

PACKAGING AND AVAILABLE SIZES

| Wire diameter (mm) | Packaging | Weight (kg) | Item number |
|--------------------|---------------|-------------|-------------|
| 1.2 | SPOOL (S200) | 5.0 | W001387177 |
| | SPOOL (BS300) | 15.0 | W000387177 |

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.