

TASETO Welding Materials

Stainless Steel Electrodes

For Flux Cored Arc Welding

GF316

Applicable Specification

JIS Z 3323 TS316-FB0

AWS A5.22 E316T0-1/4

● Applications and Characteristics

TASETO GF316 is used for welding of Type 316 stainless steel. This wire has good corrosion resistibility against non-oxidizing acids (e.g. acetic acid, dilute sulfuric acid) and salts.

● Notes on Usage

* Please refer "Guideline for Welding Stainless Steel with GF316 Wires".

● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.036	0.54	1.24	0.020	0.007	11.80	18.87	2.25	0.05

● Ferrite Content of All Weld Metal

* Typical Ferrite Content: 7.3% (Schaeffler's Diagram)
12.1FN (DeLong's Diagram)
13% (Ferrite Scope)

● Mechanical Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	5D Elongation (%)	Absorbed Energy (J at 0°C)
Typical	392	556	43.0	55

● Corrosion Resistance of All Weld Metal

*Typical Corrosion Resistance 7.78 g/m²·h (5% Sulfuric Acid Test)

● Sizes Available, Shielding Gas

Size (mm)	Shielding Gas
1.2	CO ₂ or Ar+20%CO ₂ , 20L/min
1.6	CO ₂ or Ar+20%CO ₂ , 20L/min