

# TASETO Welding Materials

Stainless Steel Electrodes

For Flux Cored Arc Welding

## GF316L

Applicable Specification

JIS Z 3323 TS316L-FB0

AWS A5.22 E316LT0-1/4

### ● Applications and Characteristics

TASETO GF316L is used for welding of Type 316 and Type 316L stainless steel. Because of low carbon content, the resistibility to intergranular corrosion of the as-welded metal is excellent, and suitable for use in the case where solution heat treatment or overlay welding with PWHT is impracticable.

### ● Notes on Usage

\* Please refer "Guideline for Welding Stainless Steel with GF316L Wires".

### ● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.026	0.52	1.46	0.024	0.006	12.22	18.44	2.69	0.04

### ● Ferrite Content of All Weld Metal

\* Typical Ferrite Content: 6.6% (Schaeffler's Diagram)  
10.8FN (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	416	522	38.0	57

### ● Corrosion Resistance of All Weld Metal

\* Typical Corrosion Resistance 5.57g/m<sup>2</sup>·h (5% Sulfuric Acid Test)  
180° bend without any defects  
(Copper Sulfate-Sulfuric Acid Test : PWHT 650°C × 2h)

### ● Sizes Available, Shielding Gas

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