

ROYAL PRIME-316L

STAINLESS STEEL FLUX-CORED WELDING WIRE
FOR WELDING 20CR-12NI-2.3MO STEEL

BASIC ALLOY: FE, MN, CR, NI, MO
AWS/SFA-5.22: E316L T 1/4
EN ISO 17633-A : T 19 12 3 L P C1 2

KEY FEATURES:

ROFIL-316L is an all position stainless steel flux cored wire designed for welding 20Cr-12Ni-2.3Mo steel and its optimum performance with 100% CO₂ gas shielding. This wire is designed with fast freezing slag characteristics and good slag detachability. It has very good deposit efficiency when used for flat, overhead, vertical and fillet welds of medium and heavy thickness plates.

APPLICATIONS

- used extensively in the fabrication of 18% Cr 12% Ni 2% Mo stainless steel structures, pressure vessels, tanks in dairy, pulp and paper, textile dyeing, refinery, and chemical equipment

SHEILDING GAS

- Welding with CO₂ gas and Ar+ CO₂ gas mixture

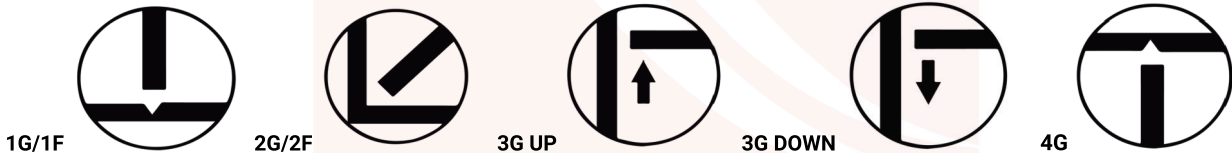
CHEMICAL COMPOSITION:

C	Mn	Si	S&P	Ni	Cr	Mo
0.030 Max.	0.50-2.50	1.00max.	0.030 Max	11.00-14.00	18.00-21.00	2.0-3.0

MECHANICAL PROPERTIES

UTS (N/mm ²)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT AT	Ferrite Content
490 Min.	35 Min.	- 30C : 27 J min.	4-10 FN

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm)	Size (inch)	Current Condition (DC+)	Voltage (V)	Spool packing 12.5 kg.	Spool packing 15kg
1.20	3/ 64"	120-300	18-22	✓	✓
1.40	1/ 18"	160-340	18-22	✓	✓
1.60	1/ 16"	180-360	18-22	✓	✓
2.00	5/64"	200-380	18-22	✓	✓