

# NST 316LT

AWS: A5.22-95: E316LT 0-4

NS-EN ISO 17633-A: T 19 12 3 L R M3

EN ISO 9606-1: FM5



## Flux cored wire for flat position and fillet welding of corrosion resistant and stainless steel materials of AISI 316, EN 1.4404 etc.

### General description:

NST 316LT is a rutile flux cored wire for flat position (PA) and fillet welding (PB and PC) of corrosion resistant and stainless steel materials such as AISI 316 etc.  
The flux cored wire uses an Argon/CO<sub>2</sub> mixed shielding gas.  
This ensures a user friendly and stable welding arc, less spatter, good visual bead appearance and smooth transition to the parent materials.  
NST 316LT has a slag freezing system which is slightly slower than wires designed for positional welding.

This makes this wire suitable for flat position and fillet welds.  
It is also suitable for use with ceramic backing for single sided welding.  
NST 316LT is also suitable for Ti- and Nb-stabilized materials when the operating temperature does not exceed 400 °C.

### Welding positions:



### Welding current:

DC+

### Gas flow:

15-23 l/min.

### Typical chemical composition of all-weld-metal:

C	Si	Mn	P	S	Cu	Ni	Cr	Mo	
0.022	0.66	1.12	0.025	0.004	0.15	11.69	18.44	2.56	

### Shielding gas:

Argon+18-25% CO<sub>2</sub>.

### Typical mechanical properties of all-weld-metal:

Yield and Tensile Strengths				
Yield Mpa(Rp0.2)	Tensile Mpa(Rm)	Elongation %		
404	552	44		

### Guidance - Ampere (DC+):

Electrode diameter			
Ampere / Volt			

### Packaging information:

0,9mm x 12,5kg D300  
1,2mm x 12,5kg D300

### Approvals:

CE, vdTÜV

### Reference / date:

NST 316LT,  
English, 13.10.2022.