



Stainless Steel flux cored wire for cryogenic application
AWS A5.22 E316LT1-1

Features and Typical fields of application

- DW-316L-EC is a rutile flux cored wire for welding 316L type stainless steel with straight CO₂ gas.
- It has excellent impact toughness down to -320°F and can satisfy lateral expansion requirements in ASME Sec. VIII (>21mils at -320°F), making it the superior choice for cryogenic application such as LNG and **Liquidified Hydrogen tank** fabrication.

Mechanical properties of all-weld metal per AWS A5.22

Shielding Gas	0.2%PS (ksi)	TS (ksi)	EI (%)	CVN (ft-lbs) at -320°F	L.E. (mils) at -320°F
100%CO ₂	54	75	41	39	32

Chemical composition of all-weld metal per AWS A5.22 (%)

Shielding Gas	C	Si	Mn	Ni	Cr	Mo	FNW*
100%CO ₂	0.02	0.36	1.16	13.2	17.9	2.0	2

*: Ferrite Number by WRC Diagram (1992)

Available Products

Wire Dia.	0.045"	Package	28 lbs spool
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DISCLAIMER

- Information in this material, such as chemical compositions and mechanical properties, is typical or an example for explaining the features and performances of our products, and it does not mean guarantee unless otherwise it is specified.
- Information contained herein is subject to change without notice. Please kindly contact Kobelco for latest information.



WARNING: This product can expose you to chemicals including Nickel and Titanium Dioxide, which are known to the State of California to cause cancer, and Chromium, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to www.P65Warnings.ca.gov.

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