

# Shield-Bright 316L X-tra

AWS A5.22 E316LT0-1(4) / EN ISO 17633-A T 19 12 3 L R M C 3 / JIS Z3323 TS316L-FB0

## Description and Application

- Shield-Bright 316L X-tra was developed for the welding type 316L stainless steel and also can be used for the other stainless steels including types 316 and 304L. In a few cases, e.g. nitric acid service, Shield-Bright 316L X-tra should not be used to weld 304L. It was designed specifically for applications where the service environment can produce pitting corrosion.

Shield-Bright 316L X-tra was developed for welding in the flat position and for horizontal fillet welds with flat to concave beads with excellent slag removal.

Flux  
CORED  
WIRES

## Shielding Gas : 100%CO<sub>2</sub> or 75%Ar/25%CO<sub>2</sub>

### Typical Mechanical Properties of All Weld Metal

| Shielding gas            | Yield Point<br>N/mm <sup>2</sup> {kgf/mm <sup>2</sup> } | Tensile Strength<br>N/mm <sup>2</sup> {kgf/mm <sup>2</sup> } | Elongation<br>(%) |
|--------------------------|---|--|-------------------|
| 100%CO <sub>2</sub>      | 431 {44}  | 565 {58}   | 37                |
| 75%Ar/25%CO <sub>2</sub> | 450 {46}  | 580 {59}   | 36                |

### Typical Undiluted Weld Metal Analysis %

| Shielding gas            | C     | Mn   | Si   | P     | S     | Cr   | Ni   | Mo   | Ferrite No. |
|--------------------------|-------|------|------|-------|-------|------|------|------|-------------|
| 100%CO <sub>2</sub>      | 0.026 | 1.47 | 0.46 | 0.024 | 0.006 | 18.5 | 12.0 | 2.70 | 8~15        |
| 75%Ar/25%CO <sub>2</sub> | 0.030 | 1.30 | 0.60 | 0.020 | 0.008 | 19.0 | 12.0 | 2.70 | 8~15        |

### Approvals

ABS, DNV, KR, LR, TUV, JIS