SelectAlloy 316LT0-3

Stainless Steel / Self Shielded / Flux Cored

PRODUCT DATA SHEET

FEATURES

- Low C, < 0.04 wt%, minimizes carbide precipitation (sensitization) which makes the weld metal more resistant to intergranular corrosion.
- The addition of Mo improves resistance to pitting and crevice corrosion compared to type 308 stainless steel.
- Designed for welding in either the flat or horizontal position where gas-shielding is not possible.
- Arc transfer is globular, with low spatter, and resulting bead is flat and well washed with a fine ripple surface.
- Applications for this alloy type include welding in the pulp and paper industry, chemical and textile processing equipment, furnace parts and in parts exposed to marine environments. Alloy types for welding include 316 stainless and similar alloys, such as A743 and A744 as well as CF-3M and CF-8M.

CONFORMANCES

AWS A5.22	E316LT0-3
ASME SFA 5.22	E316LT0-3

DIAMETERS [in [mm]]

0.045 (1.2), 1/16 (1.6), 3/32 (2.4)

POSITIONS

SHIELDING GAS

N/A

POLARITY

Direct Current Electrode Positive (DCEP)

TYPICAL WELD DEPOSIT CHEMISTRY [WT%]

Shielding Gas	C	Cr	Cu	Mn	Mo	N	Ni	P	S	Si	WRC-1992 Ferrite
N/A	0.02	19.30	0.16	1.75	2.80	0.11	13.40	0.02	<0.01	0.68	5

Bismuth is not intentionally added and levels are not known to be greater than 0.002 (WT%)

TYPICAL MECHANICAL PROPERTIES

Shielding Gas	Tensile Strength ksi (MPa)	Yield Strength ksi (MPa)	Elongation (%)	Weld Condition	PWHT Temp
N/A	88 (607)	62 (428)	38	As-Welded	-

Revision: 1/17/2025

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RECOMMENDED WELDING PARAMETERS **

Diameter in (mm)	Shielding Gas	Position	WFS* in/min (m/min)	Amps	Volts	CTWD* in (mm)
0.035 (0.9 mm)	N/A	Flat & Horizontal	450 (11.4)	120	26	3/8 (10)
		Flat & Horizontal	585 (14.9)	145	28	1/2 (13)
		Flat & Horizontal	750 (19.1)	160	32	3/4 (19)
0.045 (1.2 mm)	N/A	Flat & Horizontal	250 (6.4)	120	25	1/2 (13)
		Flat & Horizontal	430 (10.9)	175	28	5/8 (16)
		Flat & Horizontal	575 (14.6)	205	32	1 (25)
1/16 (1.6 mm)	N/A	Flat & Horizontal	215 (5.5)	165	26	5/8 (16)
		Flat & Horizontal	255 (6.5)	200	28	3/4 (19)
		Flat & Horizontal	350 (8.9)	250	32	1 (25)
3/32 (2.4 mm)	N/A	Flat & Horizontal	125 (3.2)	220	25	1 1/2 (38)
		Flat & Horizontal	180 (4.6)	300	28	1 1/2 (38)
		Flat & Horizontal	240 (6.1)	330	32	1 3/4 (44)

** WFS = Wire Feed Speed, CTWD = Contact Tip To Work Distance*
***The parameters listed are recommended starting points of operation and the ranges for amperage, wfs, and voltage could be extended based on fitness for application. For products with "all-position" capability, as determined and listed in classification, the position recommendation can be determined based on operator skill and material thickness and isn't limited to the listing.*

PACKAGING [lbs [kgs]]

33 (15) Spools, 60 (27.2) Coils, 500 (226.8) Round Drum, 800 (362.9) Hex Drum, 900 (408.2) Hex Drum

**Some packaging options may not be available depending on diameter and product. Special package options may be available upon request.*

STORAGE AND HANDLING

All products should be stored in original packaging, in dry conditions and handled with care. For more information refer to our website.

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