



Supplier of Welding Alloys

## Stainless Steel Flux Cored Wire

### Oxford Alloy® 316LT-1

**SPECIFICATIONS**

AWS 5.22  
ASME SFA 5.22

**CLASSIFICATIONS**

AWS E316LT1-1/T1-4  
UNS W31635

**DESCRIPTION / APPLICATION**

Oxford Alloy E316LT1-1/T1-4 is used for welding type 316 and 316L stainless. This flux cored wire contains molybdenum, which resists pitting corrosion induced by sulphuric and sulphurous acids, chlorides and cellulose solutions. Oxford Alloy E316LT1-1/T1-4 is used widely in the rayon, dye and paper making industries. Maximum carbon content allowed is 0.04%. Oxford Alloy E316LT1-1/T1-4 was developed for out-of-position welding. This flux cored wire will deposit out-of-position welds at substantially higher welding currents than other stainless steel flux cored wires, resulting in a higher deposition rate. The slag is self-peeling and minimizes cleanup. Oxford Alloy E316LT1-1/T1-4 was formulated for use with 75% Argon/25% CO<sup>2</sup> shielding gas; however, straight CO<sup>2</sup> may also be used. The 75/25 mixture will produce a smooth arc with virtually no spatter and slightly higher yield and tensile strengths than CO<sup>2</sup>. The mechanical properties and deposit analysis will meet AWS 5.22 specifications with either gas.

AWS Chemical Composition						
C	Mn	Si	Cr	Ni	Mo	P
0.04 max	0.5-2.5	1.0 max	17.0-20.0	11.0-14.0	2.0-3.0	0.04 max
S	Cu					
0.03 max	0.5 max					

**TYPICAL MECHANICAL PROPERTIES**

Tensile strength: 84,100 psi 560 MPa

Yield strength: 66,700 psi 460 MPa

Elongation: 38%

Please contact our sales department for more information at 800-562-3355 or 225-273-4800.

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