



Manufacturers of Custom Welding Lines for Resale
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SELECTRODE

7156

316LT1-1 Stainless Steel FC
MIG

INTERNATIONAL CLASSIFICATIONS

AWS A5.22 E316LT1-1/-4 or E316LTO-1/-4

TO = Flat and horizontal: T1 = All position: -1 is for 100% CO₂; -4 = 75-80 Ar/CO₂

FEATURES & APPLICATIONS

7156 is a flux cored wire for single or multi-pass welds on stainless steel. This wire has very low spatter, excellent bead shape, appearance and easy slag removal. It has very good deposit efficiency when used for flat and fillet welds of medium and heavy thickness plates. 7156 provides weld deposits with optimum ferrite content as its austenitic structure resulting in low susceptibility to cracking. The extra low carbon content provides excellent resistance to inter-granular corrosion and stress corrosion cracking caused by carbide precipitation. It is used extensively in the fabrication of 18% Cr, 12% Ni, 2% Mo stainless steel structures such as tanks in dairy, pulp and paper, textile dyeing, refinery and chemical equipment.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

C	Mn	Si	Cr	Mo	P	S	Ni	Fe
0.03	0.75	0.75	18.75	2.59	0.011	0.01	12.30	Bal

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Tensile Strength

Yield Strength

Maximum Value Up to:

86,600 PSI (597 MPa)

68,750PSI (474MPa)

Elongation

38%

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DCEP

Diameter	Amperage	Voltage	Wire Speed (ipm)	Stick Out
.035"(0.9mm)	100-170	23-26	265-525	¼" – ¾"
.045"(1.14mm)	120-200	24-28	250-425	½" - 1"
1/16"(1.57mm)	180-250	25-30	150-250	5/8" – 1.25"

Welding Positions: All