Covered Electrodes

KST-316L-17

For stainless steel (Low C, 18%Cr-12% Ni-Mo)

KISWEL

Classifications

EN ISO 3581-A:2012	: E 19 12 3 L R 12
EN ISO 3581-B:2012	: ES316L-17
AWS A5.4-06	: E316L-17
KS D 7014	: E316L-16
JIS Z 3221	: ES316L-17

Description

- Covering is lime titania type for welding of 18%Cr-12%Ni stainless steel (AISI 316) or dissimilar steels.
- As low carbon welded can be obtained, intergranular corrosion resistance is superior to that of E316 type.
- Good crack resistance and usability of austenitic structure with suitable ferrite of the deposited W.M.
- Excellent usability with direct current applications.

Welding positions

Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	Cu	FN
0.03	0.75	0.80	0.028	0.011	11.71	18.02	2.75	0.12	6.2

*FN: WRC 1992

Typical mechanical properties of all-weld metal

	Yield Strength (0.2%OS)	Tensile Strength	Elongation	Impact Value (J)		Remarks
	(MPa)	(MPa)	(%)	-20 °C	-196 °C	
AWS A5.4		Min. 490	Min. 30			
EN ISO 3581-A	Min. 320	Min. 510	Min. 25			
Example	420	590	45	75	26	AW

*AW: As-welded

Sizes available and recommended currents (AC or DC +)

Diameter	(mm)	2.0	2.6	3.2	4.0	5.0
Length	(mm)	250	300	350	350	350
Amperage	F	40-50	55-70	80-110	120-150	140-180
	V . OH	35-45	45-60	70-90	90-130	-