

KST-316L

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

Classifications

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

Description

- Covering is lime titania type for welding of 18%Cr-12%Ni stainless steel (AISI 316) or dissimilar steels.
- Especially suitable for flat and horizontal fillet welding.
- Excellent corrosion resistance against sulphurous acid, phosphoric acid and acetic acid.
- Redry the electrode at 250 - 350 °C for 30 – 60 minutes prior to use.



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	17.95	2.60	0.12	5.7

Typical mechanical properties of all-weld metal

	Y.S. (0.2%OS) (MPa)	T.S. (MPa)	El. (%)	IV (J)		Remarks
				-20 °C	-196 °C	
AWS A5.4		Min. 390	Min. 30			
EN ISO 3581-A	Min. 320	Min. 510	Min. 25			
Example	390	570	43	75	40 (0.47)	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
(A)	V . OH	35-45	45-60	70-90	90-130	-

Approvals

ABS	BV	DNV GL	LR	KR
E316L-16	316L	VL 316L	316Lm	RD316L

*Others: CWB, TUV, CE