

K-316LT

For Austenitic Stainless welding wire (Low C, 18%Cr-8%Ni-Mo)

Classifications

EN ISO 17633-A:2008	: T 19 12 3 L P C(M) 1
EN ISO 17633-B:2008	: TS316L-FB1
KS D 3612-2016	: YF-316LC
AWS A5.22-15	: E316LT1-1/4
JIS Z 3323	: TS316L-FB1

Approvals – C1 (100% CO₂)

ABS	: E316LT1-1
BV	: UP
DNV	: 316L MS
LR	: BF 316L S CHE
Other	: NK, KR, RINA, RS, CCS

Description

- K-316LF is designed for MAG welding of low carbon 18%Cr-12%Ni-2%Mo stainless steel and this wire has low carbon content which gives good resistance to most types of corrosion of the weld metal (AISI 316L, 316Ti, 316Cb)
- Wire is a titania type of flux cored wire for flat and horizontal position welding
- K-316LF has self-detaching slag and spray-like arc transfer, as well as excellent weldability and increased creep resistance at elevated temperature

Welding positions



Polarity & shielding gas

- DCEP (DC+)
- CO₂: 100% CO₂ (15 – 25 l/min)
- Mix: Ar + 20% CO₂ (15 – 25 l/min)

Typical chemical composition of all-weld metal (%)

Shielding Gas	C	Si	Mn	Cr	Ni	Mo	FN
CO ₂	0.03	0.58	1.38	19.50	12.50	2.4	3-8 & 8-12
Mix	0.03	0.63	1.45	19.70	12.60	2.4	

Typical mechanical properties of all-weld metal

	Yield Strength	Tensile Strength	Elongation	Impact Value (J)	
	(MPa)	(MPa)	(%)	-60°C	-105°C
AWS A5.22		Min. 485	Min. 30		
EN ISO 17633-B	Min. 320	Min. 510	Min. 25		
Example (CO ₂)	420	560	38	50	38
Example (Mix)	430	570	38	52	40

Notes on usage and welding condition

- When heat input is excessive, base metal will be bended or distorted due to the bad heat conductivity
- Therefore, perform welding with selecting proper heat input

Package

Diameter (mm)	0.9, 1.2, 1.6
Spool (kg)	5, 12.5, 15