

# K-316LF

**AWS E316LT0-1/4**  
**JIS YF316LC**  
**KS YF316LC**

FOR STAINLESS STEEL

## Typical applications

K-316LF is designed for MAG welding of low carbon 18%Cr-12%Ni-2%Mo stainless steel. This wire has low carbon content which gives good resistance to most types of corrosion of the weld metal.

## Characteristics on Usage

- ① Wire is a titania type of flux cored wire for flat and horizontal position welding.
- ② K-316LF has self-detaching slag and spray-like arc transfer.
- ③ Excellent weldability and increased creep resistance at elevated temperature
- ④ The shielding gas should be used 100%CO<sub>2</sub> and 80%Ar+20%CO<sub>2</sub> for welding.
- ⑤ Refer to page 150 for more information on usage.

## Typical chemical composition of all-weld-metal (%)

Shielding Gas	C	Si	Mn	Cr	Ni	Mo
CO <sub>2</sub>	0.03	0.65	1.58	19.4	12.4	2.42
Ar+20%CO <sub>2</sub>	0.03	0.70	1.62	19.2	12.8	2.50

## Typical mechanical properties of all-weld-metal

Shielding Gas	T · S	EI
	N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	(%)
CO <sub>2</sub>	600 {61}	39
Ar+20%CO <sub>2</sub>	620 {63}	38

## Sizes available and recommended currents (DC wire⊕)

Dia. (mm)	Amp.	Electrode extensin (mm)
1.2	100~220	10~20
1.6	160~260	15~25

## Welding positions



Approved by

JIS