

K-316T

AWS E316T0-1/4
JIS YF316C
KS YF316C

FOR STAINLESS STEEL

Typical applications

K-316T is formulated for MAG welding of 18%Cr-12%Ni-2%Mo stainless steels where increased resistance to pitting corrosion is required (AISI 316, 316L)

Characteristics on Usage

- ① K-316T is a titania type of flux cored wire for flat and horizontal position welding.
- ② Wire has low spatter, easy slag removal and good weld soundness.
- ③ The weld metal contains optimum ferrite contents in their austenitic structures, Therefore their weldability is excellent with lower crack susceptibility.
- ④ The shielding gas should be used 100%CO₂ and 80%Ar+20%CO₂ 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 ₂	0.05	0.60	1.47	18.4	12.0	2.5
Ar+20%CO ₂	0.04	0.76	1.82	18.6	11.5	2.5

Typical mechanical properties of all-weld-metal

Shielding Gas	T · S N/mm ² {kgf/mm ² }	El (%)
CO ₂	580 {59}	38
Ar+20%CO ₂	610 {62}	37

Sizes available and recommended currents (DC wire[⊕])

Dia. (mm)	Amp.	Electrode extensin (mm)
1.2	100~240	10~20
1.6	160~260	15~25

Welding positions



Approved by
 ABS, KR, JIS