

FOR STAINLESS STEEL

AWS E317LT1-1
JIS YF317LC
KS YF317LC

K-317LT

Typical applications

K-317LT is designed for MAG welding of low carbon 19%Cr-13%Ni-3%Mo stainless steels. The principal area of application is process and chemical plant, shipbuilding as well as nuclear plant industries.

(AISI 316L, 316LN, 317L, 317LN, UNS S31726)

Characteristics on Usage

- ① Wire is a titania type of flux cored wire for all-position welding.
- ② K-317LT has self-detaching slag, spray-like arc transfer, excellent weldability and increased creep resistance at elevated temperature
- ③ It contains higher levels of Mo for increased corrosion-resistance when compared to the K-316LT.
- ④ The weld metal contains optimum ferrite contents in their austenitic structures, Therefore their weldability is excellent with lower crack susceptibility.
- ⑤ The shielding gas should be used 100%CO₂ for welding.
- ⑥ 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	0.03	0.65	1.25	18.8	13.7	3.5

Typical mechanical properties of all-weld-metal

Shielding Gas	T · S N/mm ² {kgf/mm ² }	EI (%)
CO ₂	610 {62}	33

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, JIS