

FOR STAINLESS STEEL

AWS E316-15
JIS D316-15
KS D316-15

KST-316-15

Typical applications

Welding of 18%Cr-12%Ni-Mo stainless steel (AISI(SUS) 316)
Welding of dissimilar steels.

Coating

Lime titania type.

Characteristics on Usage

- ① Especially suitable for flat and horizontal fillet welding.
- ② Excellent corrosion resistance against sulphurous acid, phosphoric acid and acetic acid .
- ③ Redry the electrode at 300~350°C for 60 minutes prior to use.

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

C	Si	Mn	Cr	Ni	Mo
0.06	0.39	1.18	18.9	11.5	2.3

Typical mechanical properties of all-weld-metal

T · S N/mm ² {kgf/mm ² }	EI (%)	5%H ₂ SO ₄
580 {59}	41	5.0g/m ² · hr

Sizes available and recommended currents (DC ⊕)

Dia.	(mm)	2.0	2.6	3.2	4.0	5.0
Length	(mm)	250	300	350	350	350
Amp.	F	40~50	50~70	80~120	110~140	140~170
	V&OH	35~45	40~60	70~90	90~130	—

Welding positions



Approved by