

# KST-316

AWS E316-16  
JIS D316-16  
KS D316-16

FOR STAINLESS STEEL

## Typical applications

Welding of 18%Cr-12%Ni-Mo stainless steels (AISI316).  
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	0.73	1.18	18.3	12.5	2.3

## Typical mechanical properties of all-weld-metal

T · S N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	El (%)	5%H <sub>2</sub> SO <sub>4</sub>
570 {58}	41	4.6g/m <sup>2</sup> · hr

## Sizes available and recommended currents (AC or DC ⊕)

Dia. (mm)	2.0	2.6	3.2	4.0	5.0	
Length (mm)	250	300	350	350	350	
Amp.	F	40~50	50~80	80~120	110~150	140~180
	V&OH	35~45	45~60	70~90	90~130	—

## Welding positions



## Approved by

ABS, BV, CWB, GL