

FOR STAINLESS STEEL

AWS E316L-15  
JIS D316L-15  
KS D316L-15

# KST-316L15

## Typical applications

Welding of low carbon 18%Cr-12%Ni-Mo stainless steels, austenitic stainless steels which are required and the place where heat treatment after welding is impossible.

## Coating

Lime titania type.

## Characteristics on Usage

- ① Good crack resistance and usability.
- ② As low carbon welded metal can be obtained, intergranular corrosion resistance is superior to that of E316 type.
- 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
0.03	0.40	1.21	19.2	11.4	2.3

## Typical mechanical properties of all-weld-metal

T · S N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	EI (%)	5% <chem>H2SO4</chem>
590 {60}	39	5.0g/m <sup>2</sup> · 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	55~70	80~100	110~150	140~170
	V&OH	35~45	45~60	70~90	90~130	—

## Welding positions



Approved by