

KST-316L

AWS E316L-16
JIS D316L-16
KS D316L-16

FOR STAINLESS STEEL

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 because of austenitic structure with suitable ferrite of the deposited weld metal.
- 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	0.72	1.08	18.4	12.5	2.3

Typical mechanical properties of all-weld-metal

T · S N/mm ² {kgf/mm ² }	EI (%)	5%H ₂ SO ₄
540 {55}	43	5.0g/m ² · 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	55~70	80~110	120~150	140~180
	V&OH	35~45	45~60	70~90	90~130	-

Welding positions



Approved by

ABS, BV, CWB, DNV, GL, KR, LR, TÜV