

KST-316L-15

For stainless steel (Low C, 18%Cr-12%Ni-Mo)

Classifications

EN ISO 3581-A:2012	: E 19 12 3 L B 22	KS D 7014	: E316L-15
EN ISO 3581-B:2012	: ES316L-15	JIS Z 3221	: ES316L-15
AWS A5.4-06	: E316L-15		

Description

- Covering is lime type for welding of 18%Cr-12%Ni-Mo stainless steels, austenitic stainless steels which are required and the place where heat treatment after welding is impossible.
- Good Crack resistance and usability.
- As low carbon welded metal can be obtained, intergranular corrosion resistance is superior to that of E316 type.
- Redry the electrode at 250~350°C for 30~60 minutes prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	Cu	FN
0.03	0.40	1.08	0.025	0.006	11.67	19.22	2.43	0.30	9.8

* FN : WRC 1992

Typical mechanical properties of all-weld metal

	Y.S(0.2%OS)	T.S	EI.	IV (J)		Remarks
	(MPa)	(MPa)	(%)	-20°C	-196°C	
AWS A5.4		min. 490	min. 30			
EN ISO 3581-A	min. 320	min. 510	min. 25			
Example	400	580	39	73	25	AW

* AW : As-Welded

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
(A)	V · OH	35~45	45~60	70~90	90~130	-

Approvals

CE