

Covered Electrodes

KST-316L-17

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

Classifications

EN ISO 3581-A:2012	: E 19 12 3 L R 12	KS D 7014	: E316L-16
EN ISO 3581-B:2012	: ES316L-17	JIS Z 3221	: ES316L-17
AWS A5.4-06	: E316L-17		

Description

- Covering is lime titania type for welding of 18%Cr-12%Ni-Mo stainless steel. (AISI 316) or dissimilar steels.
- As low carbon welded metal can be obtained, intergranular corrosion resistance is superior to that of E316 type.
- Good crack resistance and usability of austenitic structure with suitable ferrite of the deposited W.M.
- Excellent usability with direct current applications.
- 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	0.75	0.80	0.028	0.011	11.71	18.02	2.75	0.12	6.2

* FN : WRC 1992

Typical mechanical properties of all-weld metal

	Y.S(0.2%OS) (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-20°C	-196°C	
AWS A5.4		min. 490	min. 30			
EN ISO 3581-A	min. 320	min. 510	min. 25			
Example	420	590	45	75	26	AW

* AW : As-Welded

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
(A)	V · OH	35~45	45-60	70-90	90-130	