

Covered Electrodes

KST-316LB

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	0.61	1.65	0.024	0.004	12.69	18.00	2.52	0.23	7.0

* 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	380	560	36	70	36(0.44)	AW

* AW : As-Welded

Sizes available and recommended currents (DC +)

Dia.	(mm)	2.6	3.2	4.0
Length	(mm)	300	350	350
Amp. (A)	F V · OH	55~80 40~60	90~130 70~90	110~150 90~130