

FOR STAINLESS STEEL

AWS E316LT1-1/4
JIS YF316LC
KS YF316LC

K-316LT

Typical applications

K-316LT is designed for MAG welding of low carbon 18%Cr-12%Ni-2%Mo stainless steels. This wire has low carbon content which gives good resistance to most types of corrosion of the weld metal (AISI 316L, 316Ti, 316Cb)

Characteristics on Usage

- ① Wire is a titania type of flux cored wire for all-position welding.
- ② K-316LT has self-detaching slag, spray-like arc transfer, excellent weldability and increased creep resistance at elevated temperature
- ③ The weld metal contains optimum ferrite contents in their austenitic structures, Therefore their weldability is excellent with lower crack susceptibility.
- ④ The shielding gas should be used 100%CO₂ and 80%Ar+20%CO₂ for welding.
- ⑤ Refer to page 150 for more information on usage.

Typical chemical composition of all-weld-metal (%)

Shielding Gas	C	Si	Mn	Cr	Ni	Mo
CO ₂	0.03	0.65	1.20	18.3	12.2	2.8
Ar+20%CO ₂	0.03	0.75	1.85	18.7	11.4	2.5

Typical mechanical properties of all-weld-metal

Shielding Gas	T · S N/mm ² {kgf/mm ² }	EI (%)
CO ₂	550 {56}	40
Ar+20%CO ₂	620 {63}	38

Sizes available and recommended currents (DC wire⊕)

Dia. (mm)	Amp.	Electrode extensin (mm)
1.2	100~240	10~20
1.6	160~260	15~25

Welding positions



Approved by

ABS, BV, DNV, KR, NK, RINA, TÜV, JIS
 (80%Ar+20%CO₂:CWB, TÜV)