K-316LT

Austenitic Stainless welding wire (Low C, 18%Cr-8%Ni-Mo)

Classifications

EN ISO 17633-A:2008	: T 19 12 3 L P C(M) 1	KS D 3612	: YF-316LC
EN ISO 17633-B:2008	: TS316L-FB1	JIS Z 3323	: TS316L-FB1
AWS A5.22-15	: E316LT1-1/4		

Description

- K-316LT is designed for MAG welding of low carbon 18%Cr-12%Ni-2%Mo stainless steels and this wire has low carbon content which gives good resistance to most types of corrosion of the weld metal (AISI 316L, 316Ti)
- Wire is a titania type of flux cored wire for all-position welding and the weld metal contains optimum ferrite contents in their austenitic structures, therefore their weldability is excellent with lower crack susceptibility.
- Wire has self-detaching slag, spray-like arc transfer, excellent weldability and increased creep resistance at elevated temperature

Welding positions



Polarity & shielding gas

- CO_2: 100% CO_2,
  Mix: Ar+20% CO_2 (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	Cr	Ni	Mo	FN
CO_2	0.03	0.60	1.15	19.50	12.70	2.40	3~8 & 8~12
Mix	0.03	0.65	1.20	19.70	12.70	2.40	

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -60℃	IV (J) -105℃	Remarks
AWS A5.22		min. 485	min. 30			
EN ISO 17633-B	min. 320	min. 510	min. 25			
Example	420	560	38	50	38	CO_2
	430	570	38	52	40	Mix

Notes on usage and welding condition

- Refer to page 303 for more information on usage
- When heat input is excessive, base metal will be bended or distorted due to the bad heat conductivity. Therefore, perform welding with selecting proper heat input

Package

Dia. (mm)	0.9	1.2	1.6
Spool (kg)		5, 12.5, 15	

Approvals

Shielding gas	ABS	BV	DNV	LR	KR	NK	RINA	RS	CCS
CO_2	E316LT1-1	UP	316L MS	BF 316L S CHE	RW 316LG(C)	KW 316LG(C)	316LS	A-6	316L