

KST-316-15

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

Classifications

EN ISO 3581-A:2012	: E 19 12 2 B 22	KS D 7014	: E316-15
EN ISO 3581-B:2012	: ES316-15	JIS Z 3221	: ES316-15
AWS A5.4-06	: E316-15		

Description

- Covering is lime type for welding of 18%Cr-12%Ni-Mo stainless steel. (AISI 316) or dissimilar steels.
- Especially suitable for flat and horizontal fillet welding.
- Excellent corrosion resistance against sulphurous acid, phosphoric acid and acetic acid.
- 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
0.06	0.39	1.18	0.029	0.013	11.59	18.88	2.30	0.11

Typical mechanical properties of all-weld metal

	Y.S (0.2%OS) (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.4		min. 520	min. 30	
EN ISO 3581-A	min. 350	min. 550	min. 25	
Example	470	580	41	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. (A)	F V · OH	40~50 35~45	50~70 40~60	80~120 70~90	110~140 90~130	140~170 -

Approvals

CE