Flux Cored Welding Wire

K-316LF

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

Classifications

EN ISO 17633-A:2010 : T 19 12 3 L R C1/M21 3
EN ISO 17633-B:2010 : TS 316L-F C1/M21 0
AWS A5.22-2012 : E316LT0-1/4
KS D 3612-2016 : YF-316LC
JIS Z 3323-2007 : TS316L-FB0

Description

- K-316LF is designed for MAG welding of low carbon 18%Cr-12%Ni-2%Mo stainless steel and this wire has low carbon content which gives good resistance to most types of corrosion of the weld metal(AISI 316L, 316Ti, 316Cb)
- Wire is a titania type of flux cored wire for flat and horizontal position welding.
- K-316LF has self-detaching slag and spray-like arc transfer, as well as 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	0.58	1.38	19.50	12.50	2.4	3~8 & 8~12
Mix	0.03	0.63	1.45	19.70	12.60	2.4	

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	440	570	37	52	40	CO_2
	440	590	36	55	42	Mix

Notes on usage and welding condition

- Refer to page 313 for more information on usage
- When heat input is excessive, the impact value tends to be reduced. Therefore, perform welding with selecting proper heat input

Package

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

Approvals

DNV*GL, JIS

* Please refer to our homepage(www.kiswel.com) for further detailed information regarding approvals.