K-316LS

Austenitic Stainless welding wire (Low C, -196℃ LNG)

Classifications

EN ISO 17633-B:2008	: TS316L-FB1	KS D 3612	: YF-316LC
AWS A5.22-15	: E316LT1-1/4	JIS Z 3323	: TS316L-FB1

Description

- K-316LS is designed for MAG welding of low carbon 18%Cr-8%Ni-2%Mo stainless steels and recommended to be use for low temperature service (AISI 316, 316L)
- It is a titania type of flux cored wire for all-position welding and formulated to focus on mechanical properties more than welding arc stability.
- The weld metal contains low ferrite contents in their austenitic micro structures and provides good corrosion resistance, heat resistance properties.

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	0.87	1.28	17.90	13.09	2.4	4~8
Mix	0.03	0.89	1.39	18.09	12.95	2.3	

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -196℃	Remarks
AWS A5.22		min. 485	min. 25		
EN ISO 17633-B	min. 320	min. 510	min. 30		
Example	420	537	35	39	CO_2
	430	541	37	39	Mix

Notes on usage and welding condition

- Refer to page 303 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

Shielding gas	ABS	BV	DNV*GL	LR	KR
CO_2	A5.22 E316LT-1	BT 316L	NV 316L	316L S	RW 316L M G