K-316LT

FLUX CORED ARC WELDING
CONSUMABLE FOR
AUSTENITIC STAINLESS STEEL

KISWEL

K-316LT

KISWEL

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.
- Wire is a titania type of flux cored wire for all-position welding and the weld metal contains optimum ferrite contents in their austenitic structure, therefore weldability is excellent with lower crack susceptibility.
- Wire has self-detaching slag, spray-like arc transfer, excellent weldability and increase creep resistance at elevated temperature

Classification

- EN ISO 17633 A : T 19 12 3 L P C1/M21 1
- EN ISO 17633 B : TS 316L-F C1/M21 1
- AWS A5.22 : E316LT1-1/4

Typical Chemical Composition of Weld metal (wt.%)

	C	Si	Mn	Cr	Ni	Mo	FN
AWS A5.22	<0.04	<1.0	0.5-2.5	17.0-20.0	11.0-14.0	2.0-3.0	-
100%CO_2	0.03	0.60	1.15	19.50	12.70	2.40	8-12
80%Ar+20%CO_2	0.03	0.65	1.20	19.70	12.70	2.40	8-12

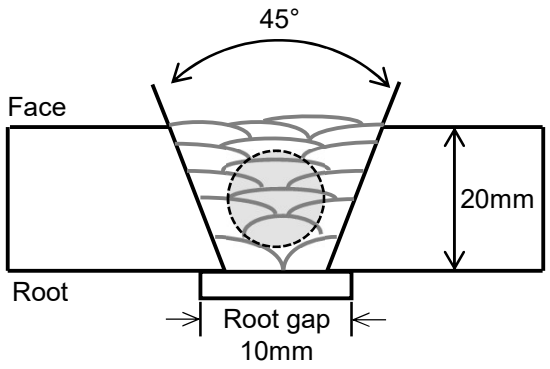
Shielding Gas

- 100%CO_2 (15~25ℓ/min)

Welding position



All Weld Metal Test Specimen



Base metal	SM490(Buttering)
Diameter	1.2mm
Current / Voltage	200A / 31V
Stick out	20mm
Travel Speed	32 CPM
Welding Position	PA / 1G

Typical Mechanical Properties of Weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	I.V (J) @ -60℃	Shielding Gas
AWS A5.22	-	>485	>30	-	CO_2
K-316LT	420	560	38	50	

Optimum Welding Conditions

Current (A)	160	200	240
Voltage (V)	28	31	34

■ Bead appearance

H-Fillet



Vertical up



■ Packaging (Size and Weight)



Dia. (mm)	0.9, 1.0, 1.2, 1.4, 1.6
Weight (kg)	5, 12.5, 15
Pail pack(kg)	-

■ Handling and Storage

- **Once flux cored wire picked up moisture, it cannot be dried at high temperature, unlike covered electrode.**
- **If a wire was left in a wire feeder in a high-temperature high - humidity atmosphere in summer season, a wet environment in rainy season or a dew fall environment at night in winter was unpacked, the wire should be kept in an area of low humidity.**

  ※ Temp. below 30℃ relative humidity below 60%

KISWEL