

Stick Electrode for Stainless Steel

KS-316

Classification

AWS A 5.4	E316-16
JIS Z3221	ES316-16
EN 3581-A	E 19 12 2 R
GB T 983	E316-16

Type of coating: Lime titania type

Applications and Features

- (1) Weld metal is 18%Cr-12%Ni-2%Mo.
- (2) It has good creep resistance at high temperature due to additional Mo content.
- (3) It provides superior weldability, easy slag removal and smooth beads.
- (4) It is suitable for welding AISI 316, mild steel and build-up on stainless steel.

Welding Position

All Positions

Welding Instruction

- (1) Please refer to Appendix H for re-drying instructions.
- (2) For other instruction information, please refer to Appendix F.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	P	S	Cr	Ni	Mo
0.050	0.35	1.30	0.015	0.010	19.55	13.23	2.52

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	5% Sulfuric Acid
N/mm ² (kgf/mm ²)	N/mm ² (kgf/mm ²)	%	Corrosion Test (g/m ² hr)
570(58.1)	410(41.8)	40	≤7

Size and Suggested Operating Range (AC or DC+)

Diameter x Length (mm)	2.0x250	2.6x300	3.2x350	4.0x350	5.0x350	
Amp	F/H-Fillet	35~55	50~85	80~120	100~150	140~200
	V-up/OH	30~50	45~85	70~110	90~135	—