

KS-316ULC

Classification

AWS	A 5.4	E316L-16
JIS	Z3221	ES316L-16
EN	3581-A	E 19 12 2 L R
GB	T 983	E316L-16

Type of coating: Lime titania type

Applications and Features

- (1) Its ultra-low carbon content prevents intergranular corrosion and brittleness.
- (2) Its slight ferrite content provides low crack susceptibility, superior corrosion and heat resistance and good mechanical properties.
- (3) It is ideal for welding critical chemical vessels, such as a heavy work piece that is difficult for heat treatment.

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
0.017	0.37	1.51	0.012	0.009	19.31	13.01	2.33

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation
N/mm ² (kgf/mm ²)	N/mm ² (kgf/mm ²)	%
560(57.1)	380(38.7)	42

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	—