

Flux Cored Wire for Stainless Steel

KFW-316LF

Classification

	AWS	A5.22	E316LT0-1/4
	JIS	Z3321	TS316-FB0
	EN	17633-A	T 19 12 3 L R C1/M21 3
Shielding Gas:	CO ₂ or Ar+20%CO ₂	GB	T 17853 E316LT0-1/4

Applications and Features

- (1) Weld metal is 18.5% Cr-12.5% Ni-2.5% Mo, which provides excellent corrosion resistance.
- (2) It is suitable for welding critical chemical vessels and AISI 316L stainless steel.
- (3) Post welding heat treatment is not required. The weld metal remains its strength at high temperature.
- (4) It has a bright silvery bead appearance and good wettability.

Welding Position

F (IG), H-Fillet (2F)

Welding Instruction

- (1) For other instructions, please refer to Appendix D.
- (2) For extra information, please refer to Appendix F.

Typical Chemical Composition of Weld Metal (wt %) (Shielding Gas : CO₂)

C	Si	Mn	P	S	Cr	Ni	Mo
0.036	0.47	1.46	0.030	0.006	19.43	12.57	2.60

Typical Mechanical Properties of Weld Metal (Shielding Gas : CO₂)

Tensile Strength N/mm ² (kgf/mm ²)	Elongation %
510(52.04)	43

Size and Suggested Operating Range (DC+)

Diameter (mm)	F/H-fillet		V/OH	
	Amp	Volt	Amp	Volt
1.2	100~300	20~36	100~200	24~30
1.6	200~360	26~40	—	—