

Flux Cored Wire for Stainless Steel

KFW-316L

Classification

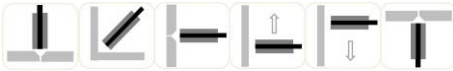
AWS	A5.22/A5.22M	E316LT1-1/4
JIS	Z3323	TS316L-FB1
EN	17633-A	T 19 12 3 L P C1/M21 2
GB	T17853	E316LT1-1/4

Shielding Gas : 100% CO₂ or Ar+20%CO₂

Applications and Features

- (1) Weld metal is austenitic structure with 18% Cr-11.5% Ni-2.2Mo.
- (2) Excellent resistance to general, pitting and intergranular corrosion due to Mo addition.
- (3) Stable arc, good slag removal, low spatters, X-ray quality welds and good penetration.
- (4) Suitable for welding critical chemical vessels and AISI 316L stainless steel.

Welding position



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%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.02	0.53	0.93	0.021	0.011	17.75	11.41	2.22

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation
N/mm ²	N/mm ²	%
574	411	37

Size and Suggested Operating Range (DC+)

Diameter (mm)		0.9	1.2	1.6
Current	Flat/H-fillet	110~150	150~220	200~300A
(A)	V-up	100~130	130~160	150~180A