

## Flux Cored Welding Wire

# K-316LF

Austenitic Stainless welding wire (Low C, 18%Cr-8%Ni-Mo)

### Classifications

EN ISO 17633-A:2010 : T 19 12 3 L R C1/M21 3      KS D 3612-2016 : YF-316LC  
 EN ISO 17633-B:2010 : TS 316L-F C1/M21 0      JIS Z 3323-2007 : TS316L-FB0  
 AWS A5.22-2012 : E316LT0-1/4

### Description

- K-316LF is designed for MAG welding of low carbon 18%Cr-12%Ni-2%Mo stainless steel and this wire has low carbon content which gives good resistance to most types of corrosion of the weld metal(AISI 316L, 316Ti, 316Cb)
- Wire is a titania type of flux cored wire for flat and horizontal position welding.
- K-316LF has self-detaching slag and spray-like arc transfer, as well as excellent weldability and increased creep resistance at elevated temperature.

### Welding positions



### Polarity & shielding gas

- CO<sub>2</sub>: 100% CO<sub>2</sub>,  
 Mix: Ar+20% CO<sub>2</sub> (15~25ℓ/min)
- DCEP (DC+)

### Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	Cr	Ni	Mo	FN
CO <sub>2</sub>	0.03	0.58	1.38	19.50	12.50	2.4	3~8 & 8~12
Mix	0.03	0.63	1.45	19.70	12.60	2.4	

### Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-60°C	-105°C	
AWS A5.22		min. 485	min. 30			
EN ISO 17633-B	min. 320	min. 510	min. 25			
Example	440	570	37	52	40	CO <sub>2</sub>
	440	590	36	55	42	Mix

### Notes on usage and welding condition

- Refer to page 313 for more information on usage
- When heat input is excessive, the impact value tends to be reduced. Therefore, perform welding with selecting proper heat input

### Package

Dia. (mm)	0.9	1.2	1.6
Spool (kg)	5, 12.5, 15		

### Approvals

DNV\*GL, JIS

\* Please refer to our homepage([www.kiswel.com](http://www.kiswel.com)) for further detailed information regarding approvals.