

**Classifications**

EN ISO 17633-A:2008	: T 19 12 3 L P C(M) 1	KS D 3612	: YF-316LC
EN ISO 17633-B:2008	: TS316L-FB1	JIS Z 3323	: TS316L-FB1
AWS A5.22-15	: E316LT1-1/4		

**Description**

- K-316LT is designed for MAG welding of low carbon 18%Cr-12%Ni-2%Mo stainless steels and this wire has low carbon content which gives good resistance to most types of corrosion of the weld metal (AISI 316L, 316Ti)
- Wire is a titania type of flux cored wire for all-position welding and the weld metal contains optimum ferrite contents in their austenitic structures, therefore their weldability is excellent with lower crack susceptibility.
- Wire has self-detaching slag, spray-like arc transfer, 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	0.60	1.15	19.50	12.70	2.40	
Mix	0.03	0.65	1.20	19.70	12.70	2.40	3-8 & 8~12

**Typical mechanical properties of all-weld metal**

	Y.S	T.S	El.	IV (J)		Remarks
	(MPa)	(MPa)		-60°C	-105°C	
AWS A5.22		min. 485	min. 30			
EN ISO 17633-B	min. 320	min. 510	min. 25			
Example	420	560	38	50	38	CO <sub>2</sub>
	430	570	38	52	40	Mix

**Notes on usage and welding condition**

- Refer to page 303 for more information on usage
- When heat input is excessive, base metal will be bended or distorted due to the bad heat conductivity. Therefore, perform welding with selecting proper heat input

**Package**

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

**Approvals**

Shielding gas	ABS	BV	DNV	LR	KR	NK	RINA	RS	CCS
CO <sub>2</sub>	E316LT1-1	UP	316L MS	BF 316L S CHE	RW 316L(G)C	KW 316L(G)C	316LS	A-6	316L