

Covered Electrodes

KST-316

For stainless steel (18%Cr-12%Ni-Mo)

Classifications

EN ISO 3581-A:2012	: E 19 12 2 R 12	KS D 7014	: E316-16
EN ISO 3581-B:2012	: ES316-16	JIS Z 3221	: ES316-16
AWS A5.4-06	: E316-16		

Description

- Covering is lime titania type for welding of 18%Cr-12%Ni-Mo stainless steel. (AISI 316) or dissimilar steels.
- Especially suitable for flat and horizontal fillet welding.
- Excellent corrosion resistance against sulphurous acid, phosphoric acid and acetic acid.
- Redry the electrode at 250~350°C for 30~60 minutes prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	Cu
0.06	0.73	1.18	0.028	0.012	12.50	18.30	2.25	0.14

Typical mechanical properties of all-weld metal

	Y.S (0.2%OS) (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.4		min. 520	min. 30	
EN ISO 3581-A	min. 350	min. 550	min. 25	
Example	460	590	42	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.0	2.6	3.2	4.0	5.0
Length	(mm)	250	300	350	350	350
Amp. (A)	F V · OH	30~50 25~45	50~80 45~60	80~110 70~90	110~140 90~130	140~180 —

Approvals

ABS	BV	GL
E316-16	UP	4432

* Others : CWB, CE