

KT-316L

Classification

AWS A5.9/A5.9M ER316L

Applications and Features

- (1) Weld metal is austenite structure with 18%Cr-12%Ni-2%Mo-Si.
- (2) Superior corrosion resistance to acetic acid, phosphoric acid, acetate and phosphate due to additional Mo content.
- (3) Ideal for welding sheets and pipes of chemical vessels, such as AISI 316, 316L steel.

Typical Chemical Composition (wt%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.018	0.44	1.847	0.009	0.010	19.14	12.65	2.56

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

Tensile Strength MPa	Yield Strength MPa	Elongation %
560	390	39

Sizes and Suggested Operating Range

Size mm	Current A	Gas Flow L/min	Shielding Gas
10	30 - 60	25	Ar
12	40 - 80	25	Ar
16	75 - 100	25	Ar
24	150 - 200	25	Ar
32	300 - 400	25	Ar