



## ENAR WELD BRAZE PVT. LTD

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### KISWEL K-316LF

#### Classifications:

EN ISO 17633-A: 2008: T 19 2 3 L R C/M 4  
EN ISO 17633-B: 2008: TS316L-FB0  
AWS A5.22-07: E316LT0-1/4

KS D 3612: YF-316LC  
JIS Z 3323: TS316L-FB0

#### Typical Chemistry Composition of Weld Deposit:

Shielding Gas	C	Si	Mn	Cr	Ni	Mo
CO <sub>2</sub>	<0.04	<1.00	0.50 – 2.50	17.00 – 20.00	11.00 – 14.00	2.00 – 3.00

#### 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.

#### Typical Mechanical Properties:

Yield Strength  
(Mpa)  
min. 320

Tensile Strength  
(Mpa)  
Min. 485

Elongation  
(%)  
min. 30