



# KISWEL

## KISWEL K-316LF

### Classifications:

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

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

### Typical Chemistry Composition of Weld Deposit:

C	Si	Mn	Cr	Ni	Mo
<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 Grades AISI 316L, 316Ti, 316Cb
- Wire is a titania type of flux cored wire for flat and horizontal position welding.
- The said wire has self-detaching slag and spray-like arc transfer with excellent weldability and increased creep resistance at elevated temperature.
- The said wire is available in Ferrite No. 3-8 or Ferrite No. 8-12

### Typical Mechanical Properties:

Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)	Impact Value (J)
min. 320	Min. 510	min. 30	40 (-105°C)

### Welding Parameters:

Wire Diameter	Shielding Gas	Current (A)		Voltage (V)	
		Min.	Max.	Min.	Max.
1.20 mm	CO <sub>2</sub>	130	280	22	30



**ENAR WELD BRAZE PVT. LTD**, Enar Chambers, A-112, DDA INDUSTRIAL SHEDS, OKHLA INDUSTRIAL AREA, PHASE - II, NEW DELHI – 110020 ☎ : 011-26383911 /12 /13 Fax : 011-26383913 e-mail : [info@enarweld.com](mailto:info@enarweld.com)

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