

Covered Electrodes

AWS E316L-16

KST-316L-16

AWS E317L-16

KST-317-16

Stainless Steel

AWS E317L-16

KST-317L-16

Typical Applications

Welding of low carbon 18%Cr-12%Ni-Mo stainless steels, austenitic stainless steels which are required and places where heat treatment after welding is impossible.

Welding of AISI(SUS)317. Welding of dissimilar steels such as carbon steel to stainless steels.

Welding of low carbon 18%Cr-12%Ni-3%Mo which requires excellent corrosion resistance to sulfuric acid and solutions containing these salts.

Characteristics Of Usage

1. Optimum ferrite in the austenitic structure helps resist weld metal cracking.
2. Better resistance to intergranular corrosion than the E316 grade.

1. Good weldability and performance.
2. Reduced susceptibility of pitting.

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Weld Metal Composition

Carbon	0.03 %
Silicon	0.72 %
Manganese	1.08 %
Chromium	18.4 %
Nickel	12.5 %
Molybdenum	2.3 %

Carbon	0.06 %
Silicon	0.74 %
Manganese	1.20 %
Chromium	18.5 %
Nickel	12.3 %
Molybdenum	3.2 %

Carbon	0.03 %
Silicon	0.75 %
Manganese	1.24 %
Chromium	18.6 %
Nickel	12.4 %
Molybdenum	3.3 %

Mechanical Properties

T-S (psi)	78,320
EI	43%
5% H ₂ SO ₄	5.0 g/m ² · hr

T-S (psi)	84,122
EI	42%
5% H ₂ SO ₄	4.6 g/m ² · hr

T-S (psi)	81,221
EI	44%
5% H ₂ SO ₄	4.0 g/m ² · hr

Available Sizes / Rec. Parameters

Dia in (mm)	Length in (mm)	Amp	
		F	V&OH
5/64 (2.0)	9.8 (250)	40-50	35-45
3/32 (2.4)	11.8 (300)	50-70	40-60
1/8 (3.2)	13.8 (350)	80-120	70-90
5/32 (4.0)	13.8 (350)	110-140	90-130
3/16 (5.0)	13.8 (350)	140-170	-

Dia in (mm)	Length in (mm)	Amp	
		F	V&OH
5/64 (2.0)	9.8 (250)	40-50	35-45
3/32 (2.4)	11.8 (300)	55-90	45-60
1/8 (3.2)	13.8 (350)	80-110	70-90
5/32 (4.0)	13.8 (350)	110-150	90-130
3/16 (5.0)	13.8 (350)	140-180	-

Dia in (mm)	Length in (mm)	Amp	
		F	V&OH
5/64 (2.0)	9.8 (250)	40-60	35-45
3/32 (2.4)	11.8 (300)	55-80	40-60
1/8 (3.2)	13.8 (350)	80-110	70-90
5/32 (4.0)	13.8 (350)	110-150	90-130
3/16 (5.0)	13.8 (350)	140-180	-

Packaging

10# (5 kg) Carton

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[Detailed Packaging Information](#)

[Detailed Packaging Information](#)

[Detailed Packaging Information](#)

Welding Positions

All Welding Positions

All Welding Positions

All Welding Positions

Approved

ABS, BV, CWB, GL, KR, LR, TUV



KISWEL
WELDING PRODUCTS

Supplier... For The Highest Demands

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