



# LKE-316-16

LINKWELD ALLOYS INC.

AWS	A5.4 E316-16
EN	EN1600 E 19 12 2 R 1 2
JIS	Z3221 D316-16

### Characteristics:

The weld metal of LKE-316 is a 18%Cr-12%Ni-2%Mo stainless steel which contains proper quantity of ferrite in austenitic structure. The corrosion resistance against sulfuric acid, phosphorous acid is excellent.

### Applications:

It is suitable for chemical plants, cladding stainless steel.

### Notes on Usage:

1. Dry the electrodes at 200-250°C for 60 minutes and keep at 100-150°C before use.
2. Use lower currents and keep the arc as short as possible.

### Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Cr	Ni	Mo
0.06	1.20	0.35	0.016	0.010	19.50	13.20	2.50

### Typical mechanical properties of weld metal

TS N/mm <sup>2</sup>	EL %
570	40

### Welding position:



### Sizes and recommended current range (AC or DC <+> )

Diameter (mm)		2.0	2.6	3.2	4.0	5.0
Length (mm)		250	300	350	350	350
Amps	F	30-55	50-85	80-120	100-150	140-180
	V&OH	20-50	45-80	70-110	90-135	-
Weight per pack(kg)		4/5	4/5	5	5	5
Weight per carton (kg)		20	20	20	20	20