

LKE-316L-16



LINKWELD ALLOYS INC.

AWS	A5.4 E316L-16
EN	EN1600 E 19 12 3 L 1 2
JIS	Z3221 D316L-16

Characteristics:

The weld metal of LKE-316L is a 18%Cr-12%Ni-2%Mo. It possesses properties to LKE-316 except with a much lower carbon content which reduces susceptibility to sensitization during welding.

Applications:

It is suitable for welding of AISI 316,316L and 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
0.03	1.20	0.35	0.016	0.010	19.50	13.20	2.50

Typical mechanical properties of weld metal

TS N/mm ²	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