

# LKE-318-16



LINKWELD ALLOYS INC.

AWS A5.4 E318-16  
JIS Z3221 D318-16

## Characteristics:

LKE-318 is a modified 316 stainless steel which contains Nb. Good corrosion resistance to sulfuric acid and organic acid can be obtained due to its Mo and Nb content.

## Applications:

It is suitable for welding of chemical vessels, pipe line and steel plate of AISI 316Ti/SUS 316-Ti.

## 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	Nb
0.04	0.85	0.75	0.030	0.010	18.50	11.50	2.50	0.40

## Typical mechanical properties of weld metal

TS N/mm <sup>2</sup>	EL %
580	41

## Welding position:



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

Diameter (mm)		2.6	3.2	4.0	4.8
Length (mm)		300	350	350	350
Amps	F	60-90	80-130	130-170	180-210
	V&OH	50-70	70-110	100-130	-
Weight per pack(kg)		4/5	5	5	5
Weight per carton (kg)		20	20	20	20