GTAW Flux Cored Wire for Stainless Steel						
	Classification					
VET VOICI	AWS A5.22/A5.22M	R316LT1-5				
NFI-ASIOL	JIS Z3323	TS316L-RI				
	EN ISO 17633-B	TS316L-RI				
Shielding Gas: 100% Ar	GB T17853	R316LT1-5				

Applications and Features

(1) KFT-X316L produces slag to protect the reverse side of the root pass from oxidation by the

atmosphere and saves the cost for back shielding gases and gas purging downtime including

the setting time for gas purging jigs.

(2) Suitable for welding 18%Cr-12%Ni-2%Mo steel (AISI 316, AISI316L).

Welding Position



Welding Instruction

- Formation of key-hole during welding is very important in order to supply slag onto reverse side bead.
- (2) The melting rate of flux cored wire is higher than that of solid wire due to flux addition. The speed of wire feeding must be higher.
- (3) Only for root pass in single-side welding, not for cover pass.

Typical Chemical Composition of Weld Metal (wt%)

с	Si	Mn	Р	S	Cr	Ni	Мо
0.02	0.85	1.53	0.020	0.011	18.91	12.54	2.35

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation
N/mm²	N/mm ²	%
617	438	40

Size and Polarity (DC-)

Diameter (mm)	2.2
Length (mm)	1000