

KST-307-15

AWS E307-15
JIS D307-15
KS D307-15

FOR STAINLESS STEEL

Typical applications

Welding of dissimilar steel such as austenitic manganese steel to carbon steel forgings.

Joining work-hardenable steels, armour plate, austenitic manganese steels, and heat-resisting steels for temperatures up to 350°C and dissimilar metals. Hardfacing of hot working tools, stainless valve steels and carbon steel items that must possess abrasion resistance in cold working.

Coating

Low hydrogen type.

Characteristics on Usage

- ① It is only used in the direct current condition.
- ② Redry the electrode at 300°C for 60 minutes prior to use.

Typical chemical composition of all-weld-metal (%)

C	Si	Mn	Cr	Ni	Mo
0.06	0.78	4.68	18.5	9.3	0.6

Typical mechanical properties of all-weld-metal

T · S N/mm ² {kgf/mm ² }	El (%)
650 {66}	48

Sizes available and recommended currents (DC ⊕)

Dia. (mm)	2.6	3.2	4.0	5.0	
Length (mm)	300	350	350	350	
Amp.	F	55~80	80~120	110~150	140~180
	V&OH	45~60	70~90	90~130	—

Welding positions



Approved by