

FOR STAINLESS STEEL

AWS E308-15
JIS D308-15
KS D308-15

KST-308-15

Typical applications

Welding of 18%Cr-8%Ni stainless steel,
(AISI 301, 302, 304, 308)

Coating

Lime titania type.

Characteristics on Usage

- ① Easy welding performance without hardening brittleness because of austenitic structure of the deposited weld metal.
- ② Good heat resistance and corrosion resistance.
- ③ Redry the electrode at 300~350°C for 30~60 minutes prior to use.

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

C	Si	Mn	Cr	Ni
0.06	0.38	1.54	20.5	9.6

Typical mechanical properties of all-weld-metal

T · S N/mm ² {kgf/mm ² }	EI (%)
600 {61}	38

Sizes available and recommended currents (DC ⊕)

Dia. (mm)	2.0	2.6	3.2	4.0	5.0	
Length (mm)	250	300	350	350	350	
Amp.	F V&OH	40~50 35~45	50~80 40~60	80~110 70~100	110~150 90~130	140~180 -

Welding positions



Approved by