

FOR STAINLESS STEEL

AWS E308L-15
JIS D308L-15
KS D308L-15

KST-308L15

Typical applications

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

Coating

Lime titania type.

Characteristics on Usage

- ① Excellent welding efficiency because of high deposition rate.
- ② Remove water, rust, oil and all foreign matters from the groove prior to welding.
- ③ Preheating is not necessary in general.
- ④ Redry the electrode at 300~350°C for 60 minutes prior to use.

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

C	Si	Mn	Cr	Ni
0.03	0.41	1.67	20.6	9.5

Typical mechanical properties of all-weld-metal

T · S N/mm ² {kgf/mm ² }	EI (%)	40% HNO_3 boiling
550 {56}	44	0.06g/m ² · hr

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	40~50	55~80	90~130	110~150	140~170
	V&OH	35~45	45~60	70~90	90~130	-

Welding positions



Approved by