

# KST-308L

AWS E308L-16  
JIS D308L-16  
KS D308L-16

FOR STAINLESS STEEL

## Typical applications

Welding of low carbon 18%Cr-8%Ni stainless steel,  
(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
0.05	0.78	1.22	19.3	9.3

## Typical mechanical properties of all-weld-metal

T · S N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	El (%)	40%HNO <sub>3</sub> boiling
550 {56}	44	0.06g/m <sup>2</sup> · hr

## Sizes available and recommended currents (AC or 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	140~180
	V&OH	35~45	45~60	70~90	90~130	-

## Welding positions



Approved by  
ABS, BV, CWB, GL, LR, TÜV