

KST-308Mo

AWS E308Mo-16
JIS D308Mo-16
KS D308Mo-16

FOR STAINLESS STEEL

Typical applications

But and Fillet welding of ASTM CF8M stainless steel castings.
Used for welding wrought materials such as Type 316L stainless when increased ferrite is desired.

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 Welds are carefully cleaned using a stainless steel wire brush.
- 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	Mo
0.05	0.36	1.42	19.8	9.4	2.1

Typical mechanical properties of all-weld-metal

T · S N/mm ² {kgf/mm ² }	El (%)	5%H ₂ SO ₄ boiling
610 {62}	38	5.0g/m ² · hr

Sizes available and recommended currents (AC or DC ⊕)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	350	350	350	350
Amp.	F	50~80	70~110	110~150	140~180
	V&OH	40~70	60~90	90~130	—

Welding positions



Approved by