

KST-309-15

AWS E309-15
JIS D309-15
KS D309-15

FOR STAINLESS STEEL

Typical applications

Welding of 22%Cr-12%Ni stainless steel and heat-resisting castings, clad side of type 304 clad steels.

Welding of dissimilar steels such as Cr-Mo steel or carbon steel to stainless steel.

Coating

Lime titania type.

Characteristics on Usage

- ① As the deposited weld metal contains ferrite in austenitic structure, its crack resistance is good.
- ② Good heat resistance and corrosion resistance.
- ③ 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	0.36	1.83	24.5	13.3

Typical mechanical properties of all-weld-metal

T · S N/mm ² {kgf/mm ² }	EI (%)
610 {62}	39

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 45~60	80~110 70~90	110~150 90~130	140~180 -

Welding positions



Approved by