

FOR STAINLESS STEEL

AWS E309-16  
JIS D309-16  
KS D309-16

# KST-309

## 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
0.06	0.72	1.36	23.6	12.6

## 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	0.08g/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	50~80	80~110	110~150	140~180
	V&OH	35~45	45~60	70~90	90~130	-

## Welding positions



## Approved by

ABS, BV, CWB, DNV, GL, KR, LR