

# KST-309L15

AWS E309L-15  
JIS D309L-15  
KS D309L-15

FOR STAINLESS STEEL

## Typical applications

Welding of 22%Cr-12%Ni steel and heat-resisting castings, clad stainless steel. Welding of dissimilar metal such as carbon steel to stainless steel.

## Coating

Lime titania type.

## Characteristics on Usage

- ① As its deposited weld metal has austenitic structure, with suitable ferrite, crack resistance is good and intergranular corrosion resistance is superior to that of E309 type.
- ② 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	0.40	1.92	24.3	13.2

## Typical mechanical properties of all-weld-metal

T · S N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	El (%)
590 {60}	38

## 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 30~50 V&OH 25~45	50~80 40~60	80~110 70~90	100~150 80~130	140~180 -

## Welding positions



Approved by