

FOR STAINLESS STEEL

AWS E309Mo-15
JIS D309Mo-15
KS D309Mo-15

KST-309Mo-15

Typical applications

Build-up welding of Cr-Mo steel or carbon steel.
Welding of AISI(SUS)316 clad steel or dissimilar steels.

Coating

Low hydrogen type.

Characteristics on Usage

- ① Excellent crack resistance especially in the welding of dissimilar steels such as stainless steel to carbon steel.
- ② It is only used in the direct current condition.
- 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	Mo
0.06	0.35	1.84	22.2	12.4	2.4

Typical mechanical properties of all-weld-metal

T · S N/mm ² {kgf/mm ² }	El (%)	5%H ₂ SO ₄ boiling
630 {64}	36	5.5g/m ² · hr

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	60~80	80~110	100~140	140~180
	V&OH	25~45	50~60	70~90	90~130	—

Welding positions



Approved by