

FOR STAINLESS STEEL

AWS E309Mo-16
JIS D309Mo-16
KS D309Mo-16

KST-309Mo

Typical applications

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

Coating

Lime titania type.

Characteristics on Usage

- ① Excellent crack resistance especially in the welding of dissimilar steels such as stainless steel to carbon steel.
- 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	Mo
0.06	0.78	1.47	23.2	12.4	2.3

Typical mechanical properties of all-weld-metal

T · S N/mm ² {kgf/mm ² }	El (%)	5%H ₂ SO ₄
630 {64}	34	5.5g/m ² · hr

Sizes available and recommended currents (AC or DC ⊕)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	300	350	350	350
Amp.	F	50~70	80~100	110~140	140~170
	V&OH	40~60	70~90	90~130	—

Welding positions



Approved by

DNV