

KST-309MoL

AWS E309MoL-16
JIS D309MoL-16
KS D309MoL-16

FOR STAINLESS STEEL

Typical applications

Build-up 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
0.03	0.76	1.78	23.2	13.1	2.4

Typical mechanical properties of all-weld-metal

T · S N/mm ² {kgf/mm ² }	EI (%)
590 {60}	41

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	30~55	55~80	90~120	100~140	140~180
	V&OH	25~45	45~60	70~90	90~130	-

Welding positions



Approved by

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