

FOR STAINLESS STEEL

AWS E310-16
JIS D310-16
KS D310-16

KST-310

Typical applications

Welding of AISI(SUS) 310S, SCS 18 and clad side of 18%Cr-8%Ni stainless clad steels.

Coating

Lime titania type.

Characteristics on Usage

- ① The deposited weld metal has perfect austenitic structure.
- ② Good mechanical property and heat resistance of the deposited weld metal.
- ③ Redry the electrode at 150~200°C for 60 minutes prior to use.

Typical chemical composition of all-weld-metal (%)

C	Si	Mn	Cr	Ni
0.11	0.40	1.86	25.6	20.8

Typical mechanical properties of all-weld-metal

T · S N/mm ² {kgf/mm ² }	El (%)	40% HNO_3
590 {60}	40	0.08g/m ² · 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	30~50	50~80	80~110	110~140	140~180
	V&OH	25~45	40~60	70~90	90~130	—

Welding positions



Approved by

CWB