

KST-312

AWS E312-16
JIS D312-16
KS D312-16

FOR STAINLESS STEEL

Typical applications

Welding of 29%Cr-9%Ni type cast steels and difficult-to-weld steels.
 Joint welding and hardfacing of stainless steel and heat-resisting steels.

Coating

Lime titania type.

Characteristics on Usage

- ① Good crack resistance because of extremely much quantity of ferrite of the deposited weld metal.
- ② Redry the electrode at 300~350°C for 30~60 minutes prior to use.

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

C	Si	Mn	Cr	Ni
0.08	0.45	1.30	29.1	8.5

Typical mechanical properties of all-weld-metal

T · S N/mm ² {kgf/mm ² }	EI (%)
770 {79}	24

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	40~80	70~110	110~140	140~180
	V&OH	35~75	70~90	80~120	—

Welding positions



Approved by