

KST-317

AWS E317-16
JIS D317-16
KS D317-16

FOR STAINLESS STEEL

Typical applications

Welding of AISI(SUS)317.

Welding of dissimilar steels such as carbon steel to stainless steels.

Coating

Lime titania type.

Characteristics on Usage

- ① Good weldability and performance.
- ② Reduce the susceptibility of pitting.
- 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 | 0.74 | 1.20 | 18.5 | 12.3 | 3.2 |

Typical mechanical properties of all-weld-metal

| T · S N/mm ² {kgf/mm ² } | El (%) | 5%H ₂ SO ₄ |
|---|-----------|----------------------------------|
| 580 {59} | 42 | 4.6g/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 | 40~60 | 55~90 | 80~110 | 110~150 | 140~180 |
| | V&OH | 35~45 | 45~60 | 70~90 | 90~130 | - |

Welding positions



Approved by