

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 V&OH 35~45	55~90 45~60	80~110 70~90	110~150 90~130	140~180 -

Welding positions



Approved by