

KST-318

AWS E318-16
JIS D318-16
KS D318-16

FOR STAINLESS STEEL

Typical applications

Welding of AISI 318, 316, 316L stainless steel

Coating

Lime titania type.

Characteristics on Usage

- ① The deposited weld metal is highly resistant to pitting and general type of corrosion.
- ② Insensitive to intergranular corrosion because of Cb.
- 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	Cb
0.05	0.76	1.32	18.5	11.9	2.3	0.7

Typical mechanical properties of all-weld-metal

T · S N/mm ² {kgf/mm ² }	El (%)	40% HNO ₃
630 {64}	38	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	40~60	50~80	80~110	120~150	140~180
	V&OH	35~45	45~60	60~90	90~130	-

Welding positions



Approved by