

# 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 <sup>2</sup> {kgf/mm <sup>2</sup> }	El (%)	40% HNO <sub>3</sub>
630 {64}	38	0.08g/m <sup>2</sup> · 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