

Covered Electrodes

KST-317L

For stainless steel (Low C, 18%Cr-12%Ni-Mo)

Classifications

EN ISO 3581-A:2012	: E 19 13 4 N L R12	KS D 7014	: E317L-16
EN ISO 3581-B:2012	: ES317L-16	JIS Z 3221	: ES317L-16
AWS A5.4-06	: E317L-16		

Description

- Covering is lime titania type for welding of 18%Cr-12%Ni-3%Mo which requires excellent corrosion resistance to sulfuric acid, solutions containing these salts and much hot organic acids such as formic acid.
- Good weldability and performance.
- Reduce the susceptibility of pitting.
- Redry the electrode at 250-350°C for 30-60 minutes prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	Cu
0.03	0.75	1.24	0.025	9.000	12.40	18.60	3.32	0.21

Typical mechanical properties of all-weld metal

	Y.S (0.2%OS) (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.4		min. 520	min. 30	
EN ISO 3581-A	min. 350	min. 550	min. 25	
Example	450	570	44	AW

* AW : As-Welded

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. (A)	F V · OH	40~60 35~45	55~90 45~60	80~110 70~90	110~150 90~130	140~180 -

Approvals

CE