

## Covered Electrodes

# KST-308H

For stainless steel (High C, 18%Cr-8%Ni)

### Classifications

EN ISO 3581-A:2012	: E 19 9 H R 12	AWS A5.4-06	: E308H-16
EN ISO 3581-B:2012	: ES308H-16	JIS Z 3221	: ES308H-16

### Description

- Covering is lime titania type for welding of 18%Cr-8%Ni stainless steel and it is recommended to be use for high temperature (about 600°C) service. (STS 304H, 307H)
- Excellent creep resistance at elevated temperature.
- Good heat resistance and corrosion resistance.
- 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
0.06	0.75	0.85	0.025	0.016	9.37	19.62	0.23	0.31

### Typical mechanical properties of all-weld metal

	Y.S (0.2%OS) (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.4		min. 550	min. 35	
EN IOS 3581-A	min. 350	min. 550	min. 30	
Example	480	600	38	AW

\* AW : As-Welded

### Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	300	350	350	350
Amp. (A)	F V · OH	50~80 40~70	70~110 60~90	110~150 90~130	140~180 -

### Approvals

CE