

KST-309LMo

For stainless steel (18%Cr-8%Ni)

Classifications

EN ISO 3581-A:2012	: E 23 12 2 L R 12	KS D 7014	: E309MoL-16
EN ISO 3581-B:2012	: ES309LMo-16	JIS Z 3221	: ES309LMo-16
AWS A5.4-06	: E309LMo-16		

Description

- Build-up welding of AISI(SUS)316 clad steel or dissimilar steels.
- Excellent crack resistance especially in the welding of dissimilar steels such as stainless steel to carbon steel.
- 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	0.76	1.78	0.026	0.013	13.02	22.84	2.15	0.12

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	490	650	35	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	30-55 25-45	55-80 45-60	90-120 70-90	100-140 90-130	140-180 -

Approvals

KR

RD309MoL

* Others : CE