

Covered Electrodes

KST-309LMoT

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

Classifications

EN ISO 3581-A:2012	: E 23 12 2 L R 12
EN ISO 3581-B:2012	: ES309LMo-17(mod.)
AWS A5.4-06	: E309LMo-17(mod.)

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
0.02	0.76	0.82	0.026	0.013	13.12	22.78	2.75	0.10

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	520	760	27	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.	F	30~55	55~80	90~120	110~140	140~180
(A)	V · OH	25~45	45~60	70~90	90~130	-