

KST-309Mo-15

For stainless steel (22%Cr-12%Ni-2.5%Mo)

Classifications

AWS A5.4-06	: E309Mo-15
KS D 7014	: E309Mo-15
JIS Z 3221	: ES309Mo-15

Description

- Build-up welding of Cr-Mo steel or carbon steel. 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.
- It is only used in the direct current condition.
- 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	0.35	1.84	0.027	0.012	12.40	22.23	2.40	0.10

Typical mechanical properties of all-weld metal

	Y.S (0.2%OS) (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.4		min. 550	min. 30	
JIS Z 3221		min. 550	min. 25	
Example	490	630	36	AW
* AW : As-Welded				

Sizes available and recommended currents (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	30~50 25~45	60~80 50~60	80~110 70~90	110~140 90~130	140~180 —