

# KST-308L-17

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

## Classifications

EN ISO3581-A:2012	: E 19 9 L R 12	KS D 7014	: E308L-16
EN ISO3581-B:2012	: ES308L-17	JIS Z 3221	: ES308L-17
AWS A5.4-06	: E308L-17		

## Description

- Covering is lime titania type for welding of 18%Cr-8%Ni stainless steel. (AISI 301, 302, 304, 308)
- Excellent welding efficiency because of high deposition rate.
- Remove water, rust, oil and all foreign matters from the groove prior to welding.
- Good usability with direct current applications.
- Preheating is not necessary in general.
- 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	FN
0.03	0.73	0.65	0.028	0.012	9.82	18.95	0.21	0.30	6.4

\* FN : WRC 1992

## Typical mechanical properties of all-weld metal

	Y.S (0.2%OS) (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-20°C	-196°C	
AWS A5.4		min. 520	min. 35			
EN ISO 3581-A	min. 320	min. 510	min. 30			
Example	440	590	46	70	25	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	40~50 35~45	55~80 40~60	90~130 70~90	110~150 90~130	140~180