

Covered Electrodes

KST-309-15

For stainless steel (Dissimilar joint welding)

Classifications

AWS A5.4-06	: E309-15
KS D 7014	: E309-15
JIS Z 3221	: ES309-15

Description

- Covering is lime type for welding of 22%Cr-12%Ni stainless steel and heat-resisting castings, clad side of type 304 clad steels.
- As the deposited weld metal contains ferrite in austenitic structure, its crack resistance is good.
- 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
0.05	0.36	1.83	0.029	0.011	13.31	24.52	0.21	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. 30	
JIS Z 3221		min. 550	min. 25	
Example	450	590	40	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.	F	40~50	50~80	80~110	110~150	140~180
(A)	V · OH	35~45	45~60	70~90	90~130	—