

Covered Electrodes

KST-309L-15

For stainless steel (Dissimilar joint welding)

Classifications

EN ISO 3581-A:2012	: E 23 12 L B 22	KS D 7014	: E309L-15
EN ISO 3581-B:2012	: ES309L-15	JIS Z 3221	: ES309L-15
AWS A5.4-06	: E309L-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. Welding of dissimilar steels such as Cr-Mo steel or carbon steel to stainless steel.
- As its deposited weld metal has austenitic structure, with suitable ferrite, crack resistance is good and intergranular corrosion resistance is superior to that of E309 type.
- 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	0.40	1.92	0.026	0.014	12.85	28.83	0.20	0.30	13.8

* FN : WRC 1992

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. 320	min. 510	min. 25	
Example	470	590	39	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	50~80 45~60	80~110 70~90	110~150 90~130	140~180 -

Approvals

CE