

Covered Electrodes

KST-308L-15

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

Classifications

EN ISO 3581-A:2012	: E 19 9 L B 22	KS D 7014	: E308L-15
EN ISO 3581-B:2012	: ES308L-15	JIS Z 3221	: ES308L-15
AWS A5.4-06	: E308L-15		

Description

- Covering is lime 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.
- 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	0.41	1.67	0.022	0.015	9.71	20.02	0.21	0.3	10.7

* FN : WRC 1992

Typical mechanical properties of all-weld metal

	Y.S (0.2%OS) (MPa)	T.S (MPa)	El. (%)	-20°C	IV (J) -196°C	Remarks
AWS A5.4		min. 520	min. 35			
EN ISO 3581-A	min. 320	min. 510	min. 30			
Example	430	590	44	65	25	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	55~80	90~130	110~150	140~180
(A)	V · OH	35~45	40~60	70~90	90~130	-

Approvals

CE