

KST-308Mo

For stainless steel (18%Cr-8%Ni-2.5%Mo)

Classifications

EN ISO 3581-A:2012	: E 20 10 3 R 12	KS D 7014	: E308Mo-16
EN ISO 3581-B:2012	: ES308Mu-16	JIS Z 3221	: ES308Mu-16
AWS A5.4-06	: E308Mo-16		

Description

- Covering is lime titania type for butt and fillet welding of ASTM CF8M stainless steel castings. Used for welding wrought materials such as Type 316L stainless when increased ferrite is desired.
- Good heat resistance and corrosion resistance.
- Welds are carefully cleaned using a stainless steel wire brush.
- 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	1.42	0.024	0.016	9.42	19.87	2.10	0.30

Typical mechanical properties of all-weld metal

	Y.S (0.2%OS) (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.4		min. 550	min. 35	
EN ISO 3581-A	min. 400	min. 620	min. 20	
Example	580	700	20	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	300	350	350	350
Amp. (A)	F V · OH	50~80 40~70	70~110 60~90	110~150 90~130	140~180 -

Approvals

CE