

Covered Electrodes

KST-309LMoT

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

Classifications

| | |
|--------------------|---------------------|
| EN ISO 3581-A:2012 | : E 23 12 2 L R 12 |
| EN ISO 3581-B:2012 | : ES309LMo-17(mod.) |
| AWS A5.4-06 | : E309LMo-17(mod.) |

Description

- Build-up welding of AISI(SUS)316 clad steel or dissimilar steels.
- Excellent crack resistance especially in the welding of dissimilar steels such as stainless steel to carbon steel.
- 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 |
|------|------|------|-------|-------|-------|-------|------|------|
| 0.02 | 0.76 | 0.82 | 0.026 | 0.013 | 13.12 | 22.78 | 2.75 | 0.10 |

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. 350 | min. 550 | min. 25 | |
| Example | 520 | 760 | 27 | 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. | F | 30~55 | 55~80 | 90~120 | 110~140 | 140~180 |
| (A) | V · OH | 25~45 | 45~60 | 70~90 | 90~130 | - |