

KST-308L

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

Classifications

EN ISO 3581-A:2012	: E 19 9 L R 12	KS D 7014	: E308L-16
EN ISO 3581-B:2012	: ES308L-16	JIS Z 3221	: ES308L-16
AWS A5.4-06	: E308L-16		

Description

- Covering is lime titania 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	0.73	0.65	0.028	0.012	10.07	18.86	0.21	0.30	5.3

Typical mechanical properties of all-weld metal

	Y.S. (0.2%OS) (MPa)	T.S. (MPa)	El. (%)	IV (J)		Remarks
				-20 °C	-196 °C	
AWS A5.4		Min. 520	Min. 35			
EN ISO 3581-A	Min. 320	Min. 510	Min. 30			
Example	430	600	44	65	25	AW

*AW: As-welded

Sizes available and recommended currents (AC or DC +)

Diameter	(mm)	2.0	2.6	3.2	4.0	5.0
Length	(mm)	250	300	350	350	350
Amperage	F	40-50	55-80	90-130	110-150	140-180
(A)	V . OH	35-45	40-60	70-90	90-130	-

Approvals

ABS	BV	DNV GL	LR
E308L-16	308L	VL 308L	304Lm

*Others: CWB, TUV, CE