

# KST-312

For stainless steel (Cladding or Dissimilar joint)

## Classifications

EN ISO 3581-A:2012	: E 29 9 R 12
EN ISO 3581-B:2012	: ES312-16
AWS A5.4-06	: E312-16
KS D 7014	: E312-16
JIS Z 3221	: ES312-16

## Approvals

Other	: CE
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## Description

- Covering is lime titania type for welding of 29%Cr-9%Ni type cast steels and difficult to weld steel
- Joint welding and hardfacing of stainless steel and heat resisting steels
- Good crack resistance because of extremely high quantity of ferrite of the deposited weld metal
- 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
0.08	0.45	1.30	0.028	0.012	8.49	29.13	0.10	0.11

## Typical mechanical properties of all-weld metal

	Yield Strength (0.2%OS)	Tensile Strength	Elongation	Remarks
	(MPa)	(MPa)	(%)	
AWS A5.4		Min. 660	Min. 22	
EN ISO 3581-A	Min. 450	Min. 650	Min. 15	
Example	510	760	25	AW

\*AW: As-welded

## Sizes available and recommended currents (AC or DC +)

Diameter	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	300	350	350	350
Amperage	F	40-80	70-110	110-140	140-180
	V . OH	35-75	70-90	80-120	-