Covered Electrodes

KST-308L

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

KISWEL

Classifications

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

Approvals

ABS	: E308L-16
BV	: 308L
DNV	: VL 308L
LR	: 304Lm
Other	: CWB, TUV, CE

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

	Yield Strength (0.2%OS)	Tensile Strength	Elongation	Impact Value (J)		Remarks
	(MPa)	(MPa)	(%)	-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
	V . OH	35-45	40-60	70-90	90-130	-