

# KST-308

**AWS E308-16**  
**JIS D308-16**  
**KS D308-16**

FOR STAINLESS STEEL

## Typical applications

Welding of 18%Cr-8%Ni stainless steel  
(AISI 301, 302, 304 ,308)

## Coating

Lime titania type.

## Characteristics on Usage

- ① Easy welding performance without hardening brittleness because of austenitic structure of the deposited weld metal.
- ② Good heat resistance and corrosion resistance.
- ③ Redry the electrode at 300~350°C for 30~60 minutes prior to use.

## Typical chemical composition of all-weld-metal (%)

C	Si	Mn	Cr	Ni
0.05	0.78	1.22	19.3	9.3

## Typical mechanical properties of all-weld-metal

T · S N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	El (%)	40% HNO <sub>3</sub> boiling
580 {59}	44	0.09g/m <sup>2</sup> · hr

## 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	40~50	50~80	80~110	110~150	140~180
	V&OH	35~45	40~60	70~100	90~130	-

## Welding positions



## Approved by

ABS, BV, CWB, DNV, GL, KR