

FOR STAINLESS STEEL

AWS E309L-16
JIS D309L-16
KS D309L-16

KST-309L

Typical applications

Welding of 22%Cr-12%Ni steel and heat-resisting castings, clad stainless steel. Welding of dissimilar metal such as carbon steel to stainless steel.

Coating

Lime titania type.

Characteristics on Usage

- ① As its deposited weld metal has austenitic structure, with suitable ferrite, crack resistance is good and intergranular corrosion resistance is superior to that of E309 type.
- ② Redry the electrode at 300~350°C for 60 minutes prior to use.

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

C	Si	Mn	Cr	Ni
0.03	0.71	1.34	23.7	12.6

Typical mechanical properties of all-weld-metal

T · S N/mm ² {kgf/mm ² }	El (%)	40%HNO ₃
550 {56}	44	0.06g/m ² · 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	30~50	50~80	80~110	110~150	140~180
	V&OH	25~45	40~60	70~90	90~130	—

Welding positions



Approved by
ABS, CWB