KST-318

For stainless steel (18%Cr-12%Ni-2%Mo-Nb)

Classifications

AWS A5.4-06 : E318-16
KS D 7014 : E318-16
JIS Z 3221 : ES318-16

Description

- Covering is lime titania type for welding of AISI 318, 316, 316L stainless steel.
- The deposited weld metal is highly resistant to pitting and general type of corrosion.
- Insensitive to intergranular corrosion because of Nb.
- Redry the electrode at 250~350℃ for 30~60 minutes prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	Nb
0.05	0.76	1.32	0.022	0.008	11.90	18.43	2.35	0.69

Typical mechanical properties of all-weld metal

	Y.S (0.2%OS) (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.4		min. 550	min. 25	
JIS Z 3221		min. 550	min. 20	
Example	500	630	38	AW

* AW : As-Welded

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	40~60	50~80	80~110	120~150	140~180
(A)	V · OH	35~45	45~60	60~90	90~130	–