

## Covered Electrodes

# KST-310

For stainless steel (25%Cr-20%Ni)

### Classifications

EN ISO 3581-A:2012	: E 25 20 R 12	KS D 7014	: E310-16
EN ISO 3581-A:2012	: ES310-16	JIS Z 3221	: ES310-16
AWS A5.4-06	: E310-16		

### Description

- Covering is lime titania type for welding of AISI(SUS) 310S, SCS 18 and clad side of 18%Cr-8%Ni stainless clad steel.
- The deposited weld metal has perfect austenitic structure.
- Good mechanical property and heat resistance 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
0.11	0.40	1.86	0.025	0.013	20.82	25.59	0.12	0.09

### Typical mechanical properties of all-weld metal

	Y.S (0.2%OS) (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.4		min. 550	min. 30	
EN ISO 3581-A	min. 350	min. 550	min. 20	
Example	490	620	40	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. (A)	F V · OH	30-50 25-45	50-80 45-60	80-110 70-90	110-140 90-130	140-180 -

### Approvals

CWB, CE