

Stick Electrode for Stainless Steel

KS-307

Classification

AWS A 5.4	E307-16
JIS Z3221	ES307-16
EN 3581-A	E 18 9 Mn Mo R
GB T 983	E307-16

Type of coating: Lime titania type

Applications and Features

- (1) Weld metal is 18%Cr-8%Ni-4%Mn.
- (2) It has low crack susceptibility.
- (3) It is suitable for welding thick plate, rigid joints, and 14% high Manganese steel, armor steel and hard-to-weld steel.

Welding Position

All Positions

Welding Instruction

- (1) Please refer to Appendix H for re-drying instructions.
- (2) For other instructions and information, please refer to Appendix F.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	P	S	Cr	Ni	Mo
0.090	0.50	4.25	0.010	0.010	19.74	9.85	1.00

Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm ² (kgf/mm ²)	Yield Strength N/mm ² (kgf/mm ²)	Elongation %
600(61.2)	480(49.0)	42

Size and Suggested Operating Range (AC or DC+)

Diameter x Length (mm)	2.0x250	2.6x300	3.2x350	4.0x350	5.0x350	
Amp	F/H-Fillet	35~55	50~85	80~120	100~150	140~200
	V-up/OH	30~50	45~85	70~110	90~135	—