

## Stick Electrode for Stainless Steel

# KS-308LT

### Classification

AWS	A 5.4	E308L-16
JIS	Z3221	ES308L-16
EN	3581-A	E 19 9 L R
GB	T 983	E308L-16

Type of coating: Lime titania type

### Applications and Features

- (1) It is ideal for welding chemical equipment, vessels and pipes of liquid helium, liquid hydrogen, liquid nitrogen and liquid natural gas.
- (2) It has excellent impact properties at low temperature.
- (3) It is also suitable for applications which require low magnetism.

### 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
0.030	0.34	1.60	0.013	0.007	19.12	10.91

### Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch
N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	%	°C J (kgf-m)
560(57.1)	410 (41.8)	43	-196 38(3.9)

### 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	—