

Stick Electrode for Stainless Steel

KS-308EL

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 provides excellent weldability, easy slag removal and smooth beads.
- (2) It has better corrosion resistance than KS-308L due to extra low carbon content.
- (3) It is suitable for welding low carbon 18%Cr-8%Ni steel, such as AISI 304L.
- (4) 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
0.020	0.55	1.35	0.020	0.008	19.45	9.81

Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm ² (kgf/mm ²)	Yield Strength N/mm ² (kgf/mm ²)	Elongation %
530(54.1)	390(39.8)	47

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	—