

Stick Electrode for Stainless Steel

KS-312BLUE

Classification

AWS	A 5.4	E312-16
JIS	Z3221	ES312-16
EN	3581-A	E 29 9 R
GB	T 983	E312-16

Type of coating: Lime titania type

Applications and Features

- (1) It is widely used for welding dissimilar metals due to low crack susceptibility.
- (2) It provides good weldability, low spatter, easy slag removal and amazingly smooth beads.
- (3) It is suitable for welding clad steel, stainless steel sheet linings, hard-to-weld steel, high porosity susceptible steel and alloy steel with high hardenability.

Welding Position

All Positions

Welding Instruction

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

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	P	S	Cr	Ni
0.120	0.49	1.35	0.015	0.010	28.52	9.45

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation
N/mm ² (kgf/mm ²)	N/mm ² (kgf/mm ²)	%
790(80.6)	620(63.2)	25

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	—