

Stick Electrode for Stainless Steel

KS-318

Classification

AWS A 5.4	E318-16
JIS Z3221	ES318-16
EN 3581-A	E 19 23 Nb R
GB T 983	E318-16

Type of coating: Lime titania type

Applications and Features

- (1) Weld metal is 18%Cr-12%Ni-2%Mo with additional Nb.
- (2) It provides superior corrosion and heat resistance than KS-316 due to additional Nb content.
- (3) It is ideal for welding critical chemical vessels and AISI 316Ti.

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	Mo
0.060	0.35	1.66	0.016	0.010	19.23	13.10	2.40

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation
N/mm ² (kgf/mm ²)	N/mm ² (kgf/mm ²)	%
590(60.2)	420(42.8)	41

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	—