

Covered Electrodes

AWS E307-15

KST-307-15

Typical Applications

Welding of dissimilar steel and joining work hardenable steels, armor plate, austenitic manganese steels, and heat-resisting steels for temperatures up to 662°F.

Characteristics Of Usage

1. For use on direct current electrode positive only.

Weld Metal Composition

Carbon	0.06 %
Silicon	0.78 %
Manganese	4.68 %
Chromium	18.50 %
Nickel	9.30 %
Molybdenum	0.60 %

Mechanical Properties

T-S (psi)	94,275
EI	48 %

Available Sizes / Rec. Parameters

Dia in (mm)	Length in (mm)	Amp	
		Flat	V&OH
3/32 (2.4)	11.8 (300)	55-80	45-60
1/8 (3.2)	13.8 (350)	80-120	70-90
5/32 (4.0)	13.8 (350)	110-150	90-130
3/16 (5.0)	13.8 (350)	140 -180	-

Packaging

10# (5 kg) Carton

Detailed Packaging Information

Welding Positions

All Welding Positions

Approved

AWS E308-15

KST-308-15

Welding of 18%Cr-8%Ni stainless steel, (AISI 301, 302, 304 ,308).

1. Good performance without hardening brittleness due to austenitic structure of the deposited weld metal.
2. Good heat resistance and corrosion resistance.

Carbon	0.06 %
Silicon	0.38 %
Manganese	1.54 %
Chromium	20.50 %
Nickel	9.60 %

T-S (psi)	87,023
EI	38 %

Dia in (mm)	Length in (mm)	Amp	
		Flat	
5/64 (2.0)	9.8 (250)	40-50	
3/32 (2.4)	11.8 (300)	50-80	
1/8 (3.2)	13.8 (350)	80-110	
5/32 (4.0)	13.8 (350)	110-150	
3/16 (5.0)	13.8 (350)	140 -180	

10# (5 kg) Carton

Detailed Packaging Information

All Welding Positions

Stainless Steel

AWS E308-16

KST-308-16

Welding of 18%Cr-8%Ni stainless steel (AISI 301, 302, 304 ,308)

1. Good performance without hardening brittleness due to austenitic structure of the deposited weld metal.
2. Good heat resistance and corrosion resistance.

Carbon	0.05 %
Silicon	0.78 %
Manganese	1.22 %
Chromium	19.30 %
Nickel	9.30 %

T-S (psi)	84,122
EI	44 %
40 % HNO ₃	0.09 g/m ² · hr

Dia in (mm)	Length in (mm)	Amp	
		Flat	V&OH
5/64 (2.0)	9.8 (250)	40-50	35-45
3/32 (2.4)	11.8 (300)	50-80	40-60
1/8 (3.2)	13.8 (350)	80-110	70-100
5/32 (4.0)	13.8 (350)	110-150	90-130
3/16 (5.0)	13.8 (350)	140-180	-

10# (5 kg) Carton

Detailed Packaging Information

All Welding Positions

ABS, BV, CWB, DNV, GL, KR

