

Covered Electrodes

AWS E309L-16

KST-309L-16

AWS E309Mo-15

KST-309Mo-15

Stainless Steel

AWS E309Mo-16

KST-309Mo-16

Typical Applications

Welding of 22%Cr-12%Ni steel and heat-resisting castings, clad stainless steel. Welding of dissimilar metal such as carbon steel to stainless steel.

Build-up welding of Cr-Mo steel or carbon steel. Welding of AISI(SUS)316 clad steel or dissimilar steels.

Build-up welding of Cr-Mo steel or carbon steel. Welding of AISI(SUS)316 clad steel or dissimilar steels.

Characteristics Of Usage

1. The deposited weld metal has optimal ferrite levels to resist weld metal cracking.
2. Product also has excellent resistance to corrosion and intergranular attack.

1. Excellent crack resistance especially in the welding of dissimilar steels such as stainless steel to carbon steel.
2. Product intended for use with direct current only.

1. Excellent crack resistance especially in the welding of dissimilar steels such as stainless steel to carbon steel.

Weld Metal Composition

Carbon	0.03 %
Silicon	0.71 %
Manganese	1.34 %
Chromium	23.7 %
Nickel	12.6 %

Carbon	0.06 %
Silicon	0.35 %
Manganese	1.84 %
Chromium	22.2 %
Nickel	12.4 %
Molybdenum	2.4 %

Carbon	0.06 %
Silicon	0.78 %
Manganese	1.47 %
Chromium	23.2 %
Nickel	12.4 %
Molybdenum	2.3 %

Mechanical Properties

T-S (psi)	79,771
EI	44 %
40% HNO ₃	0.06 g/m ² · hr

T-S (psi)	91,374
EI	36 %
5% H ₂ SO ₄	5.5 g/m ² · hr

T-S (psi)	91,374
EI	34 %
5% H ₂ SO ₄	5.5 g/m ² · hr

Available Sizes / Rec. Parameters

Dia in (mm)	Length in (mm)	Amp	
		F/H-Fil	V&OH
5/64 (2.0)	9.8 (250)	30-50	25-45
3/32 (2.4)	11.8 (300)	50-80	40-60
1/8 (3.2)	13.8 (350)	80-110	70-90
5/32 (4.0)	13.8 (350)	110-150	90-130
3/16 (5.0)	13.8 (350)	140-180	-

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

Dia in (mm)	Length in (mm)	Amp	
		Flat	V&OH
3/32 (2.4)	11.8 (300)	50-70	40-60
1/8 (3.2)	13.8 (350)	80-100	70-90
5/32 (4.0)	13.8 (350)	110-140	90-130
3/16 (5.0)	13.8 (350)	140-170	-

Packaging

10# (5 kg) Carton

10# (5 kg) Carton

10# (5 kg) Carton

[Detailed Packaging Information](#)

[Detailed Packaging Information](#)

[Detailed Packaging Information](#)

Welding Positions

All Welding Positions

All Welding Positions

All Welding Positions

Approved

ABS, CWB

DNV



KISWEL
WELDING PRODUCTS

Supplier... For The Highest Demands

[SEARCH](#)

[CONTENTS](#)