

Stick Electrode for Stainless steel

KS-312-17

Classification

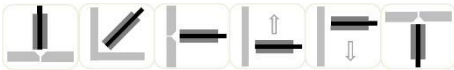
AWS A5.4/A5.4M	E312-17
JIS Z3221	ES312-17
EN ISO 3581-A	-
GB T983	E312-17

Coating Type : Lime Titania

Applications and Features

- (1) Weld metal is austenitic structure with 29%Cr-9%Ni.
- (2) Suitable for dissimilar joints welding in stainless steel and carbon steel, welding difficulty, blowhole possibility, and toughness alloy.

Welding Position



Welding Instruction

- (1) Please refer to Appendix A.
- (2) Please refer to Appendix F.

Typical Weld Metal Composition (wt%)

C	Si	Mn	P	S	Cr	Ni
0.12	0.88	0.71	0.027	0.007	28.03	9.89

Typical Weld Metal Mechanical Properties

Tensile strength	Yield strength	Elongation
N/mm ²	N/mm ²	%
831	583	25

Available Sizes and Welding Parameters (AC or DC+)

Diameter (mm)		2.6	3.2	4.0	5.0
Current (A)	F/HF	50~85	80~120	100~150	140~180
	V-up/OH	45~80	70~110	90~135	-