

# For Stainless Steel

## KST307-15

### Typical Applications:

Welding of dissimilar steel such as austenitic manganese steel to carbon steel forgings. Joining work-hardenable steels, armour plate, austenitic manganese steels, and heat-resisting steels for temperatures up to 350°C and dissimilar metals.

Hard facing of hot working tools, stainless valve steels and carbon steel items that must possess abrasion resistance in cold working.

Coating: Low Hydrogen type

### Characteristics on Usage:

1. It is only used in the direct current condition.
2. Redry the electrode at 300 °C for 60 minutes prior to use.

### Typical chemical composition of all weld metal (%)

C	Si	Mn	Cr	Ni	Mo
0.06	0.78	4.68	18.5	9.3	0.6

### Typical mechanical properties of all weld metal

T - S	El
N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	%
650 (66)	48

### Sizes available, packaging and recommended currents (AC or DC+)

Dia (mm)	2.6	3.2	4.0	5.0
Length (mm)	300	350	350	350
AMP F	55-80	80-120	110-150	140-180
V & OH	45-60	70-90	90-130	-----

### Welding Positions:



*Glass  
House  
Specialized  
Supplies*

