



KISWEL
WELDING PRODUCTS

For Stainless Steel

KST 312-L

The KST-312 electrode is lime titania coated and used for welding of 29%CR-9%Ni type cast steels and difficult to weld steels. Also joint welding and hardfacing of stainless steel and heat resisting steels. The electrode has good crack resistance due to the high quality of ferrite in the deposited weld metal.



Typical mechanical properties of all-weld-metal:

T.S.	EI
<i>N/mm² (kgf/mm²)</i>	<i>(%)</i>
<i>770 (79)</i>	<i>24</i>

Sizes available and recommended currents (AC or DC+):

<i>Dia (mm)</i>	<i>2.6</i>	<i>3.2</i>	<i>4.0</i>
<i>Length (mm)</i>	<i>300</i>	<i>350</i>	<i>350</i>
<i>Amp. F</i>	<i>40-80</i>	<i>70-110</i>	<i>110-140</i>
<i>Amp. V & OH</i>	<i>35-75</i>	<i>70-90</i>	<i>80-120</i>

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