

KST-307-15

For stainless steel (19%Cr-9%Ni-5%Mn)

Classifications

AWS A5.4-06	: E307-15
KS D 7014	: E307-15
JIS Z 3221	: ES307-15

Description

- 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. Hardfacing of hot working tools, stainless valve steels and carbon steel items that must possess abrasion resistance in cold working.
- Redry the electrode at 250~350°C for 30~60 minutes prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	Cu
0.06	0.76	4.68	0.028	0.012	9.30	18.50	0.60	0.30

Typical mechanical properties of all-weld metal

	Y.S (0.2%OS) (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.4		min. 590	min. 30	
JIS Z 3221		min. 590	min. 25	
Example	470	650	48	AW

* AW : As-Welded

Sizes available and recommended currents (DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	300	350	350	350
Amp. (A)	F V · OH	55~80 45~60	80~120 70~90	100~150 90~130	140~180 —