



KINGSTEEL

STAINLESS STEEL (Austenitic Steel)

KEY FEATURES:

- Rutile type coating
- Excellent corrosion and scaling resistance
- Smooth and stable arc
- Minimal spatter
- Self peeling slag
- Excellent welder appeal
- Deposits 308L type of weld metal
- All position capability
- Radiographic quality welds

TYPICAL APPLICATIONS:

- Welding Cr-Ni steels represented by AISI 301, 302, 304, 304L, 308, 308L
- For Structural Welding applications



TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni
0.03	1.5	0.8	18	9

MECHANICAL PROPERTIES OF ALL WELD METAL:

Condition	UTS, Mpa	EL%
As Welded	520 min	35 min

PARAMETERS - PACKING DATA:

Ø x L, mm 2.5 x 350 3.15 x 350 4.0 x 350	Amperage, A 50-75 80-100 110-140	 AC (50 OCV) / DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Down 
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Available in Standard carton packing of 10 kg box containing 5 cartons of 2 kg each.