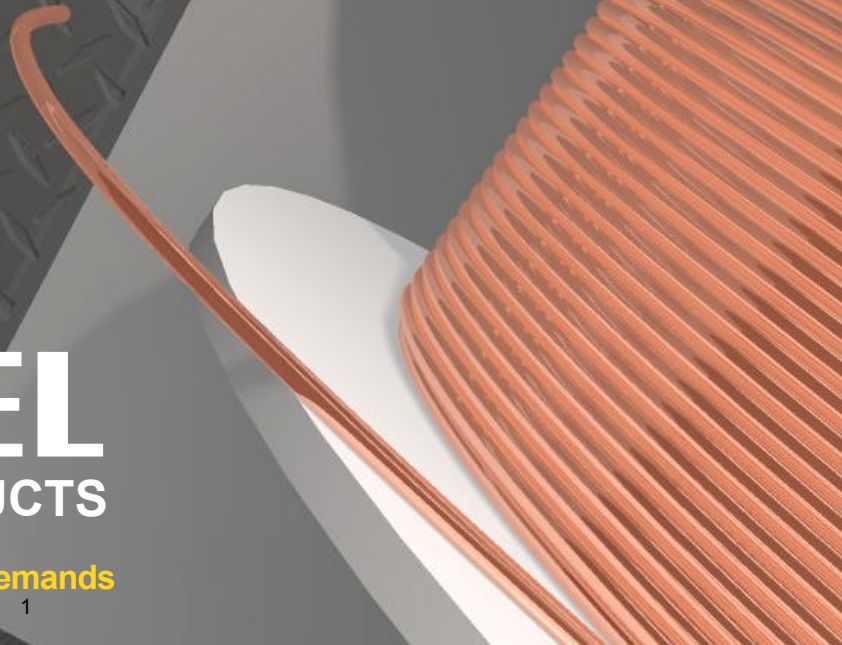
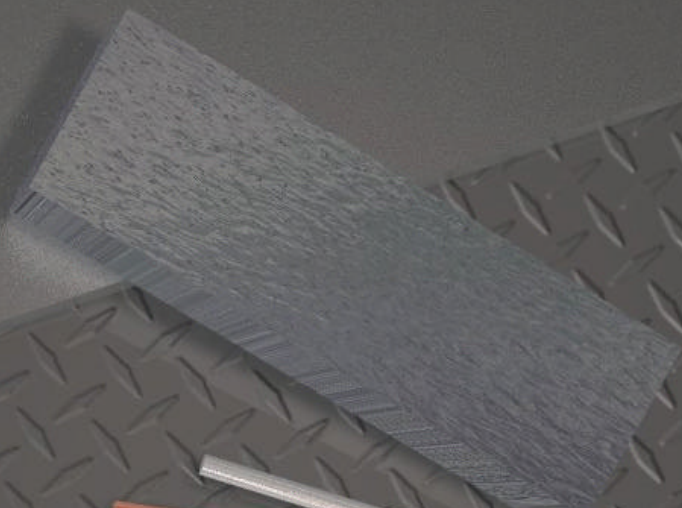
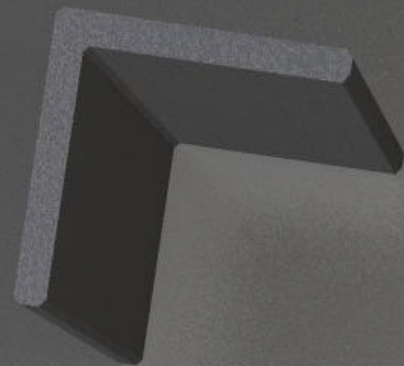


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KISWEL
WELDING PRODUCTS

Supplier... For The Highest Demands

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KISWEL
WELDING PRODUCTS

Supplier... For The Highest Demands

PRODUCTS:

Covered Electrodes:

Mild Steel
High Tensile
Low Hydrogen
Stainless Steel

Tubular Wires:

Mild Steel
Self-Shielded
Metal Cored
Stainless Steel

MIG Wires:

Mild Steel
High Tensile Steel
Stainless Steel

TIG Wires:

Mild Steel
Stainless Steel

SUPPORT:

Contacts:

Customer Services
Corporate Addresses

Packaging:

Covered Electrodes
Tubular Wires
MIG Wires
TIG Wires

Please Read Carefully

Precautions and Safe Practices



WARNING



PROTECT YOURSELF AND OTHERS. READ AND UNDERSTAND THIS INFORMATION.

FUMES AND GASES can be dangerous to your health. The gas ozone can be irritating if inhaled and can cause delayed lung injury. **ARC RAYS** can injure eyes and burn skin. **ELECTRIC SHOCK** can kill.

Keep your head out of the fumes. Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases away from your breathing zone and general area. Wear correct eye, ear and body protection. Do not touch live electrical parts. **FIRST AID:** If exposed to excess welding fumes, remove to fresh air. In case of arc rays, or electrical shock, employ normal first aid techniques and call a physician immediately.

Protect yourself and others. Read and understand the manufacturer's instructions and your employer's safety practices. See Material Safety Data Sheets (MSDS) for more information about use and disposal. See American National Standard Z49.1, Safety in Welding and Cutting, published by the American Welding Society, 550 N. W. LeJeune Road, Miami, FL 33126, OSHA Safety and Health Standards, CFR 1910 available from the U.S. Government Printing Office, Washington, D.C. 20402

Do not remove this information. For industrial use only. **WARNING:** These products contain or produce chemicals known to the State of California to cause cancer, birth defects or other reproductive harm (Prop 65)

- Do Not Remove, Cover, Or Destroy This Warning -



PRECAUCIÓN: Los humos y gases de soldadura pueden ser peligrosos para su salud. Utilice ventilación adecuada para alejar los humos del área de respiración. Los rayos del arco pueden dañar los ojos y quemar la piel. Utilice los medios adecuados para proteger las manos, ojos, cabeza y cuerpo. Lea y comprenda la Hoja de Datos de Seguridad del Producto.



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WELDING PRODUCTS

Supplier... For The Highest Demands

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KISWEL
WELDING PRODUCTS

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Covered Electrodes

Mild Steel

High Tensile Steel

Low Hydrogen Steel

Stainless Steel



KISWEL
WELDING PRODUCTS

Supplier... For The Highest Demands

Covered Electrodes

AWS E6010

KCL-10

Typical Applications

Used in pressure piping, ship building, tank assembly, galvanized steels and casting repairs.

Characteristics Of Usage

1. Excellent penetration with good fusion makes this the preferred choice for pipeline welding.
2. Low slag volume results and easy slag removal with good bead appearance.

Weld Metal Composition

Carbon	0.10 %
Silicon	0.20 %
Manganese	0.47 %
Phosphorus	0.014 %
Sulphur	0.012 %

Mechanical Properties

Y-P (psi)	60,916
T-S (psi)	72,519
EI	24 %
V-Notch	37 ft/lb @ -20°F

Available Sizes / Rec. Parameters

Dia inches	Amp	
	Flat	V&OH
3/32 (2.4)	50-80	40-70
1/8 (3.2)	70-110	60-100
5/32 (4.0)	110-150	90-130
3/16 (5.0)	160-200	140-170

Packaging

10# (5 kg) Carton

Detailed Packaging Information

Welding Positions

Flat, Vertical, Horizontal and Overhead

Approved

ABS, BV, CWB, LR, NK, JIS

AWS E6011

KCL-11

Welding of steel plates and sheet, piping and ship construction.

1. Excellent all position general construction electrode designed for use on both DC and AC current.
2. Slightly higher slag volume than E6010 with good bead appearance.
3. Produces good mechanical properties, meets x-ray requirements.

Carbon	0.08 %
Silicon	0.37 %
Manganese	0.66 %
Phosphorus	0.015 %
Sulphur	0.013 %

Y-P (psi)	59,465
T-S (psi)	72,519
EI	24 %
V-Notch	37 ft/lb @ -20°F

Dia inches	Length inches	Amp
		Flat
3/32 (2.4)	11.8 (300)	50-80
1/8 (3.2)	13.8 (350)	70-110
5/32 (4.0)	13.8 (350)	110-150
3/16 (5.0)	13.8 (350)	160 -200

10# (5 kg) Carton

Detailed Packaging Information

Flat, Vertical, Horizontal and Overhead

ABS, CWB, DNV, LR, JIS

Mild Steel

AWS E6013

KR-3000

Used for light to medium construction work for all position. Excellent operator appeal. Works well with poor fit-up applications.

1. Excellent striking and restriking properties.
2. Excellent slag removal and arc transfer.
3. Excellent bead appearance without undercut.

Carbon	0.07 %
Silicon	0.32 %
Manganese	0.45 %
Phosphorus	0.015 %
Sulphur	0.012 %

Y-P (psi)	62,366
T-S (psi)	69,618
EI	29 %
V-Notch	52 ft/lb @ -20°F

Dia inches	Length inches	Amp	
		Flat	V&OH
3/32 (2.4)	13.8 (350)	60-100	60-90
1/8 (3.2)	13.8 (350)	80-130	80-120
5/32 (4.0)	15.7 (400)	130-180	90-140
3/16 (5.0)	15.7 (400)	160-220	120-190
1/4 (6.0)	17.7 (450)	210-280	-

10# (5 kg) Carton

Detailed Packaging Information

Flat, Vertical, and Overhead

ABS, BV, CWB, DNV, GL, KR, LR, NK, JIS, KS



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WELDING PRODUCTS

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Covered Electrodes

AWS E7024

K-7024

High Tensile Steel

Typical Applications

Flat and horizontal fillet welding of ship structures, bridges, structural steels for buildings and general structures.

Characteristics Of Usage

1. Designed for high efficiency in single and multiple pass welds.
2. Quiet and stable arc with good bead appearance and excellent operator appeal.
3. Easy slag removal, self-releasing.

Weld Metal Composition

Carbon	0.08 %
Silicon	0.35 %
Manganese	0.78 %
Phosphorus	0.016 %
Sulphur	0.012 %

Mechanical Properties

Y-P (psi) 69,618
T-S (psi) 82,672
EI 28 %
V-Notch 52 ft/lb @ 32°F

Available Sizes / Rec. Parameters

Dia in (mm)	Length in (mm)	Amp	
		Flat	H-Fil
1/8 (3.2)	11.8 (300)	100-150	100-150
5/32 (4.0)	13.8 (350)	140-190	140-190
3/16 (5.0)	13.8 (350)	200-250	200-250
7/32 (5.6)	13.8 (350)	230-270	230-270

Packaging

10# (5 kg) Carton

[Detailed Packaging Information](#)

Welding Positions

Flat and Horizontal Welding Positions

Approved

ABS, BV, CWB, DNV, GL, KR, LR, NK, JIS



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WELDING PRODUCTS

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Covered Electrodes

AWS E7018

K-7018

Typical Applications

Welding of 71 ksi class high tensile strength steels of ships, bridges, storage tanks, building, industrial machinery and mining machinery.

Characteristics Of Usage

1. Excellent usability with direct current applications.

Weld Metal Composition

Carbon	0.07 %
Silicon	0.57 %
Manganese	0.97 %
Phosphorus	0.012 %
Sulphur	0.010 %

Mechanical Properties

Y-P (psi)	69,618
T-S (psi)	82,672
EI	30%
V-Notch	66 ft/lb @ -20°F

Available Sizes / Rec. Parameters

Dia in (mm)	Length in (mm)	Amp	
		Flat	V&OH
3/32 (2.4)	13.8 (350)	60-100	50-80
1/8 (3.2)	13.8 (350)	90-130	80-120
5/32 (4.0)	15.7 (400)	130-180	110-170
3/16 (5.0)	15.7 (400)	200-250	160-210

Packaging

10# (5 kg) Carton

Detailed Packaging Information

Welding Positions

All Welding Positions

Approved

ABS, BV, CWB, DNV, GL, KR, LR, NK, JIS, KS

AWS E7018-1

K-7018N

Welding of nuclear reactor vessels, pressure vessels, LPG tankers, LPG storage tanks and similar installations at low temperature.

1. Excellent impact value at -51°F.
2. Excellent mechanical properties.

Carbon	0.07 %
Silicon	0.58 %
Manganese	1.38 %
Nickel	0.15 %

Y-P (psi)	73,969
T-S (psi)	85,572
EI	32 %
V-Notch	96 ft/lb @ -51°F

Dia in (mm)	Length in (mm)	Amp	
		Flat	V&OH
3/32 (2.4)	13.8 (350)	70-100	60-90
1/8 (3.2)	13.8 (350)	90-130	85-120
5/32 (4.0)	15.7 (400)	150-190	110-160
3/16 (5.0)	15.7 (400)	160-220	130-180
1/4 (6.0)	17.7 (450)	180-230	-

10# (5 kg) Carton

Detailed Packaging Information

All Welding Positions

CWB, DNV, LR

Low Hydrogen

AWS E8018-G

K-8018

Welding of 78 ksi class high strength low alloy steel of ships, bridges, storage tanks and buildings.

1. Excellent mechanical properties with good crack resistance of deposited weld metal.

Carbon	0.06 %
Silicon	0.54 %
Manganese	1.08 %
Nickel	0.31 %
Molybdenum	0.20 %

Y-P (psi)	71,068
T-S (psi)	85,572
EI	28 %
V-Notch	110 ft/lb @ -20°F

Dia in (mm)	Length in (mm)	Amp	
		Flat	V&OH
3/32 (2.4)	13.8 (350)	60-90	50-80
1/8 (3.2)	13.8 (350)	90-130	80-110
5/32 (4.0)	15.7 (400)	140-190	120-170
3/16 (5.0)	15.7 (400)	180-230	160-200
1/4 (6.0)	17.7 (450)	250-300	-

10# (5 kg) Carton

Detailed Packaging Information

All Welding Positions

ABS, JIS



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WELDING PRODUCTS

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Covered Electrodes

AWS E9018-M

K-9018M

AWS E11018-M

K-11018M

Low Hydrogen

Typical Applications

Welding of 85.5 ksi class high strength low alloy steel of pressure vessels, bridges, machinery and penstocks.

Welding of low alloy high strength steels having tensile properties of about 107-114 ksi steels such as HY80, etc.

Characteristics Of Usage

1. Excellent mechanical properties especially in notch toughness.
2. Meets stringent radiographic standards for welding of alloy steels.

1. Excellent operational performance in all positions.
2. Good impact value at -60° F.

Weld Metal Composition

Carbon	0.07 %
Silicon	0.51 %
Manganese	1.10 %
Chromium	0.10 %
Nickel	1.58 %
Molybdenum	0.20 %

Carbon	0.08 %
Silicon	0.41 %
Manganese	1.49 %
Chromium	0.32 %
Nickel	1.86 %
Molybdenum	0.32 %

Mechanical Properties

Y-P (psi)	82,672
T-S (psi)	97,175
EI	30 %
V-Notch	66 ft/lb @ -60°F

Y-P (psi)	104,427
T-S (psi)	118,931
EI	23 %
V-Notch	44 ft/lb @ -60°F

Available Sizes / Rec. Parameters

Dia in (mm)	Length in (mm)	Amp	
		Flat	V&OH
3/32 (2.4)	13.8 (350)	50-100	40-80
1/8 (3.2)	13.8 (350)	90-130	80-115
5/32 (4.0)	15.7 (400)	140-190	110-160
3/16 (5.0)	15.7 (400)	190-240	140-170
1/4 (6.0)	17.7 (450)	250-310	-

Dia in (mm)	Length in (mm)	Amp	
		Flat	V&OH
3/32 (2.4)	13.8 (350)	50-100	40-90
1/8 (3.2)	13.8 (350)	90-130	80-120
5/32 (4.0)	15.7 (400)	130-180	110-160
3/16 (5.0)	15.7 (400)	180-240	140-200
1/4 (6.0)	17.7 (450)	250-320	-

Packaging

10# (5 kg) Carton

10# (5 kg) Carton

[Detailed Packaging Information](#)

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Welding Positions

Flat, Vertical, Horizontal and Overhead

Flat, Vertical, Horizontal and Overhead

Approved



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Covered Electrodes

AWS E307-15

KST-307-15

Typical Applications

Welding of dissimilar steel and joining work hardenable steels, armor plate, austenitic manganese steels, and heat-resisting steels for temperatures up to 662°F.

Characteristics Of Usage

1. For use on direct current electrode positive only.

Weld Metal Composition

Carbon	0.06 %
Silicon	0.78 %
Manganese	4.68 %
Chromium	18.50 %
Nickel	9.30 %
Molybdenum	0.60 %

Mechanical Properties

T-S (psi)	94,275
EI	48 %

Available Sizes / Rec. Parameters

Dia in (mm)	Length in (mm)	Amp	
		Flat	V&OH
3/32 (2.4)	11.8 (300)	55-80	45-60
1/8 (3.2)	13.8 (350)	80-120	70-90
5/32 (4.0)	13.8 (350)	110-150	90-130
3/16 (5.0)	13.8 (350)	140 -180	-

Packaging

10# (5 kg) Carton

Detailed Packaging Information

Welding Positions

All Welding Positions

Approved

AWS E308-15

KST-308-15

Welding of 18%Cr-8%Ni stainless steel, (AISI 301, 302, 304 ,308).

1. Good performance without hardening brittleness due to austenitic structure of the deposited weld metal.
2. Good heat resistance and corrosion resistance.

Carbon	0.06 %
Silicon	0.38 %
Manganese	1.54 %
Chromium	20.50 %
Nickel	9.60 %

T-S (psi)	87,023
EI	38 %

Dia in (mm)	Length in (mm)	Amp
		Flat
5/64 (2.0)	9.8 (250)	40-50
3/32 (2.4)	11.8 (300)	50-80
1/8 (3.2)	13.8 (350)	80-110
5/32 (4.0)	13.8 (350)	110-150
3/16 (5.0)	13.8 (350)	140 -180

10# (5 kg) Carton

Detailed Packaging Information

All Welding Positions

Stainless Steel

AWS E308-16

KST-308-16

Welding of 18%Cr-8%Ni stainless steel (AISI 301, 302, 304 ,308)

1. Good performance without hardening brittleness due to austenitic structure of the deposited weld metal.
2. Good heat resistance and corrosion resistance.

Carbon	0.05 %
Silicon	0.78 %
Manganese	1.22 %
Chromium	19.30 %
Nickel	9.30 %

T-S (psi)	84,122
EI	44 %
40 % HNO ₃	0.09 g/m ² · hr

Dia in (mm)	Length in (mm)	Amp	
		Flat	V&OH
5/64 (2.0)	9.8 (250)	40-50	35-45
3/32 (2.4)	11.8 (300)	50-80	40-60
1/8 (3.2)	13.8 (350)	80-110	70-100
5/32 (4.0)	13.8 (350)	110-150	90-130
3/16 (5.0)	13.8 (350)	140-180	-

10# (5 kg) Carton

Detailed Packaging Information

All Welding Positions

ABS, BV, CWB, DNV, GL, KR



KISWEL
WELDING PRODUCTS

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Covered Electrodes

AWS E308L-15

KST-308L-15

Typical Applications

Welding of low carbon 18%Cr-8%Ni stainless steel, (AISI 301, 302, 304, 308, (AISI(SUS)304L).

Characteristics Of Usage

1. Excellent welding efficiency because of high deposition rate.
2. Remove water, rust, oil and all foreign matters from the groove prior to welding.
3. Preheating is not necessary in general.

Weld Metal Composition

Carbon	0.03 %
Silicon	0.41 %
Manganese	1.67 %
Chromium	20.6 %
Nickel	9.5 %

Mechanical Properties

T-S (psi)	79,771
EI	44 %
40 % HNO₃	0.06 g/m ² · hr

Available Sizes / Rec. Parameters

Dia in (mm)	Length in (mm)	Amp	
		Flat	V&OH
5/64 (2.0)	9.8 (250)	40-50	35-45
3/32 (2.4)	11.8 (300)	55-80	45-60
1/8 (3.2)	13.8 (350)	90-130	70-90
5/32 (4.0)	13.8 (350)	110-150	90-130
3/16 (5.0)	13.8 (350)	140-170	-

Packaging

10# (5 kg) Carton

Detailed Packaging Information

Welding Positions

All Welding Positions

Approved

AWS E308L-16

KST-308L-16

Welding of low carbon 18%Cr-8%Ni stainless steel (AISI (SUS) 304L).

1. Excellent welding efficiency because of high deposition rate.
2. Remove water, rust, oil and all foreign matters from the groove prior to welding.

Carbon	0.05 %
Silicon	0.78 %
Manganese	1.22 %
Chromium	19.3 %
Nickel	9.3 %

T-S (psi)	79,771
EI	44 %
40 % HNO₃	0.06 g/m ² · hr

Dia in (mm)	Length in (mm)	Amp	
		Flat	V&OH
5/64 (2.0)	9.8 (250)	40-50	35-45
3/32 (2.4)	11.8 (300)	55-80	45-60
1/8 (3.2)	13.8 (350)	90-130	70-90
5/32 (4.0)	13.8 (350)	110-150	90-130
3/16 (5.0)	13.8 (350)	140-180	-

10# (5 kg) Carton

Detailed Packaging Information

All Welding Positions

ABS, BV, CWB, GL, LR, TUV

Stainless Steel

AWS E308Mo-16

KST-308Mo-16

Butt and Fillet welding of ASTM CF8M stainless steel castings. Used for welding wrought materials such as Type 316L stainless when increased ferrite is desired.

1. Welds without brittleness due to structure of deposited weld metal.
2. Good heat and corrosion resistance.
3. All welds should be cleaned with a clean stainless steel wire brush.

Carbon	0.05 %
Silicon	0.36 %
Manganese	1.42 %
Chromium	19.8 %
Nickel	9.4 %
Molybdenum	2.1 %

T-S (psi)	88,473
EI	38 %
5 % H₂SO₄	5.0 g/m ² · hr

Dia in (mm)	Length in (mm)	Amp	
		Flat	V&OH
3/32 (2.4)	13.8 (350)	50-80	40-70
1/8 (3.2)	13.8 (350)	70-110	60-90
5/32 (4.0)	13.8 (350)	110-150	90-130
3/16 (5.0)	13.8 (350)	140-180	-

10# (5 kg) Carton

Detailed Packaging Information

All Welding Positions



KISWEL
WELDING PRODUCTS

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Covered Electrodes

AWS E309-15

KST-309-15

AWS E309-16

KST-309-16

Stainless Steel

AWS E309L-15

KST-309L-15

Typical Applications

Welding of 22%Cr-12%Ni stainless steel and heat-resisting castings, clad side of type 304 clad steels. Welding of dissimilar steels such as Cr-Mo steel or carbon steel to stainless steel.

Welding of 22%Cr-12%Ni stainless steel and heat-resisting castings, clad side of type 304 clad steels. Welding of dissimilar steels such as Cr-Mo steel or carbon steel to stainless steel.

Welding of 22%Cr-12%Ni steel and heat-resisting castings, clad stainless steel. Welding of dissimilar metal such as carbon steel to stainless steel.

Characteristics Of Usage

- 1.The deposited weld metal contains optimized levels of ferrite to resist weld metal cracking.
- 2.Good heat resistance and corrosion resistance.

1. The deposited weld metal contains optimized levels of ferrite to resist weld metal cracking.
2. Good heat resistance and corrosion resistance.

1. The deposited weld metal contains optimized levels of ferrite to resist weld metal cracking.

Weld Metal Composition

Carbon	0.05 %
Silicon	0.36 %
Manganese	1.83 %
Chromium	24.5 %
Nickel	13.3 %

Carbon	0.06 %
Silicon	0.72 %
Manganese	1.36 %
Chromium	23.6 %
Nickel	12.6 %

Carbon	0.03 %
Silicon	0.40 %
Manganese	1.92 %
Chromium	24.3 %
Nickel	13.3 %

Mechanical Properties

T-S (psi)	88,473
EI	39 %

T-S (psi)	79,771
EI	44 %
40% HNO₃	0.08 g/m ² · hr

T-S (psi)	85,572
EI	38 %

Available Sizes / Rec. Parameters

Dia in (mm)	Length in (mm)	Amp	
		Flat	V&OH
5/64 (2.0)	9.8 (250)	40-50	35-45
3/32 (2.4)	11.8 (300)	55-80	45-60
1/8 (3.2)	13.8 (350)	80-110	70-90
5/32 (4.0)	13.8 (350)	110-150	90-130
3/16 (5.0)	13.8 (350)	140-180	-

Dia in (mm)	Length in (mm)	Amp	
		Flat	V&OH
5/64 (2.0)	9.8 (250)	40-50	35-45
3/32 (2.4)	11.8 (300)	55-80	45-60
1/8 (3.2)	13.8 (350)	90-130	70-90
5/32 (4.0)	13.8 (350)	110-150	90-130
3/16 (5.0)	13.8 (350)	140-170	-

Dia in (mm)	Length in (mm)	Amp	
		Flat	V&OH
5/64 (2.0)	9.8 (250)	30-50	25-45
3/32 (2.4)	11.8 (300)	50-80	40-60
1/8 (3.2)	13.8 (350)	80-110	70-90
5/32 (4.0)	13.8 (350)	100-150	80-130
3/16 (5.0)	13.8 (350)	140-180	-

Packaging

10# (5 kg) Carton

10# (5 kg) Carton

10# (5 kg) Carton

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[Detailed Packaging Information](#)

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Welding Positions

All Welding Positions

All Welding Positions

All Welding Positions

Approved



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Covered Electrodes

AWS E309L-16

KST-309L-16

Typical Applications

Welding of 22%Cr-12%Ni steel and heat-resisting castings, clad stainless steel. Welding of dissimilar metal such as carbon steel to stainless steel.

Characteristics Of Usage

1. The deposited weld metal has optimal ferrite levels to resist weld metal cracking.
2. Product also has excellent resistance to corrosion and intergranular attack.

Weld Metal Composition

Carbon	0.03 %
Silicon	0.71 %
Manganese	1.34 %
Chromium	23.7 %
Nickel	12.6 %

Mechanical Properties

T-S (psi)	79,771
EI	44 %
40 % HNO₃	0.06 g/m ² · hr

Available Sizes / Rec. Parameters

Dia in (mm)	Length in (mm)	Amp F/H-Fil	V&OH
5/64 (2.0)	9.8 (250)	30-50	25-45
3/32 (2.4)	11.8 (300)	50-80	40-60
1/8 (3.2)	13.8 (350)	80-110	70-90
5/32 (4.0)	13.8 (350)	110-150	90-130
3/16 (5.0)	13.8 (350)	140-180	-

Packaging

10# (5 kg) Carton

Detailed Packaging Information

Welding Positions

All Welding Positions

Approved

ABS, CWB

AWS E309Mo-15

KST-309Mo-15

Build-up welding of Cr-Mo steel or carbon steel. Welding of AISI(SUS)316 clad steel or dissimilar steels.

1. Excellent crack resistance especially in the welding of dissimilar steels such as stainless steel to carbon steel.
2. Product intended for use with direct current only.

Carbon	0.06 %
Silicon	0.35 %
Manganese	1.84 %
Chromium	22.2 %
Nickel	12.4 %
Molybdenum	2.4 %

T-S (psi)	91,374
EI	36 %
5 % H₂SO₄	5.5 g/m ² · hr

Dia in (mm)	Length in (mm)	Amp Flat	V&OH
3/32 (2.4)	11.8 (300)	60-80	50-60
1/8 (3.2)	13.8 (350)	80-110	70-90
5/32 (4.0)	13.8 (350)	100-140	90-130
3/16 (5.0)	13.8 (350)	140-180	-

10# (5 kg) Carton

Detailed Packaging Information

All Welding Positions

Stainless Steel

AWS E309Mo-16

KST-309Mo-16

Build-up welding of Cr-Mo steel or carbon steel. Welding of AISI(SUS)316 clad steel or dissimilar steels.

1. Excellent crack resistance especially in the welding of dissimilar steels such as stainless steel to carbon steel.

Carbon	0.06 %
Silicon	0.78 %
Manganese	1.47 %
Chromium	23.2 %
Nickel	12.4 %
Molybdenum	2.3 %

T-S (psi)	91,374
EI	34 %
5 % H₂SO₄	5.5 g/m ² · hr

Dia in (mm)	Length in (mm)	Amp Flat	V&OH
3/32 (2.4)	11.8 (300)	50-70	40-60
1/8 (3.2)	13.8 (350)	80-100	70-90
5/32 (4.0)	13.8 (350)	110-140	90-130
3/16 (5.0)	13.8 (350)	140-170	-

10# (5 kg) Carton

Detailed Packaging Information

All Welding Positions

DNV



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Covered Electrodes

AWS E309MoL-16

KST-309MoL-16

AWS E310-16

KST-310-16

Stainless Steel

AWS E312-16

KST-312-16

Typical Applications

Build-up welding of AISI(SUS)316 clad steel or dissimilar steels.

Welding of AISI(SUS) 3105, SCS 18 and clad side of 18%Cr-8%Ni stainless clad steels.

Welding of 29%Cr-9%Ni type cast steels and difficult-to-weld steels. Joint welding and hardfacing of stainless steel and heat-resisting steels.

Characteristics Of Usage

1. Excellent crack resistance especially in the welding of dissimilar steels such as stainless steel to carbon steel.

1. The deposited weld metal has optimized austenitic structure.
2. Good mechanical property and heat resistance of the deposited weld metal.

1. Improved crack resistance due to high quantity of ferrite in the deposited weld metal.

Weld Metal Composition

Carbon	0.03 %
Silicon	0.76 %
Manganese	1.78 %
Chromium	23.2 %
Nickel	13.1 %
Molybdenum	2.4 %

Carbon	0.11 %
Silicon	0.40 %
Manganese	1.86 %
Chromium	25.6 %
Nickel	20.8 %

Carbon	0.08 %
Silicon	0.45 %
Manganese	1.30 %
Chromium	29.1 %
Nickel	8.5 %

Mechanical Properties

T-S (psi)	85,572
EI	41 %

T-S (psi)	85,572
EI	40 %
40% HNO ₃	0.08 g/m ² · hr

T-S (psi)	111,679
EI	24 %

Available Sizes / Rec. Parameters

Dia in (mm)	Length in (mm)	Amp Flat	V&OH
5/64 (2.0)	9.8 (250)	30-55	25-45
3/32 (2.4)	11.8 (300)	55-80	45-60
1/8 (3.2)	13.8 (350)	90-120	70-90
5/32 (4.0)	13.8 (350)	100-140	90-130
3/16 (5.0)	13.8 (350)	140 - 180	-

Dia in (mm)	Length in (mm)	Amp Flat	V&OH
5/64 (2.0)	9.8 (250)	30-50	25-45
3/32 (2.4)	11.8 (300)	50-80	40-60
1/8 (3.2)	13.8 (350)	80-110	70-90
5/32 (4.0)	13.8 (350)	110-140	90-130
3/16 (5.0)	13.8 (350)	140 - 180	-

Dia in (mm)	Length in (mm)	Amp F	V&OH
3/32 (2.4)	11.8 (300)	40-80	35-75
1/8 (3.2)	13.8 (350)	70-110	70-90
5/32 (4.0)	13.8 (350)	110-140	80-120
3/16 (5.0)	13.8 (350)	140 - 180	-

Packaging

10# (5 kg) Carton

10# (5 kg) Carton

10# (5 kg) Carton

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Welding Positions

All Welding Positions

All Welding Positions

All Welding Positions

Approved

KR

CWB



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Covered Electrodes

AWS E316-15

KST-316-15

Typical Applications

Welding of 18%Cr-12%Ni-Mo stainless steel (AISI(SUS) 316). Welding of dissimilar steels.

Characteristics Of Usage

1. Especially suitable for flat and horizontal fillet welding.
2. Excellent corrosion resistance against sulphurous acid, phosphoric acid and acetic acid.

Weld Metal Composition

Carbon	0.06 %
Silicon	0.39 %
Manganese	1.18 %
Chromium	18.9 %
Nickel	11.5 %
Molybdenum	2.3 %

Mechanical Properties

T-S (psi)	84,122
EI	41 %
5% H₂SO₄	0.06 g/m ² · hr

Available Sizes / Rec. Parameters

Dia in (mm)	Length in (mm)	Amp	
		F	V&OH
5/64 (2.0)	9.8 (250)	40-50	35-45
3/32 (2.4)	11.8 (300)	50-70	40-60
1/8 (3.2)	13.8 (350)	80-120	70-90
5/32 (4.0)	13.8 (350)	110-140	90-130
3/16 (5.0)	13.8 (350)	140 -170	-

Packaging

10# (5 kg) Carton

Detailed Packaging Information

Welding Positions

All Welding Positions

Approved

AWS E316-16

KST-316-16

Welding of 18%Cr-12%Ni-Mo stainless steels (AISI316). Welding of dissimilar steels.

1. Especially suitable for flat and horizontal fillet welding.
2. Excellent corrosion resistance against sulphurous acid, phosphoric acid and acetic acid.

Carbon	0.06 %
Silicon	0.73 %
Manganese	1.18 %
Chromium	18.3 %
Nickel	12.5 %
Molybdenum	2.3 %

T-S (psi)	82,672
EI	41 %
5% H₂SO₄	4.6 g/m ² · hr

Dia in (mm)	Length in (mm)	Amp	
		F	V&OH
5/64 (2.0)	9.8 (250)	40-50	35-45
3/32 (2.4)	11.8 (300)	50-80	45-60
1/8 (3.2)	13.8 (350)	80-120	70-90
5/32 (4.0)	13.8 (350)	110-150	90-130
3/16 (5.0)	13.8 (350)	140 -180	-

10# (5 kg) Carton

Detailed Packaging Information

All Welding Positions

ABS, BV, CWB, GL

Stainless Steel

AWS E316L-15

KST-316L-15

Welding of low carbon 18%Cr-12%Ni-Mo stainless steels, austenitic stainless steels which are required and places where heat treatment after welding is impossible.

1. Good crack resistance and usability.
2. Better resistance to intergranular corrosion than the E316 grade.

Carbon	0.03 %
Silicon	0.40 %
Manganese	1.21 %
Chromium	19.2 %
Nickel	11.4 %
Molybdenum	2.3 %

T-S (psi)	85,572
EI	39 %
5% H₂SO₄	5.0 g/m ² · hr

Dia in (mm)	Length in (mm)	Amp	
		F	V&OH
5/64 (2.0)	9.8 (250)	40-50	35-45
3/32 (2.4)	11.8 (300)	55-70	45-60
1/8 (3.2)	13.8 (350)	80-100	70-90
5/32 (4.0)	13.8 (350)	110-150	90-130
3/16 (5.0)	13.8 (350)	140 -170	-

10# (5 kg) Carton

Detailed Packaging Information

All Welding Positions



KISWEL
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Covered Electrodes

AWS E316L-16

KST-316L-16

Typical Applications

Welding of low carbon 18%Cr-12%Ni-Mo stainless steels, austenitic stainless steels which are required and places where heat treatment after welding is impossible.

Characteristics Of Usage

1. Optimum ferrite in the austenitic structure helps resist weld metal cracking.
2. Better resistance to intergranular corrosion than the E316 grade.

Weld Metal Composition

Carbon	0.03 %
Silicon	0.72 %
Manganese	1.08 %
Chromium	18.4 %
Nickel	12.5 %
Molybdenum	2.3 %

Mechanical Properties

T-S (psi)	78,320
EI	43%
5% H ₂ SO ₄	5.0 g/m ² · hr

Available Sizes / Rec. Parameters

Dia in (mm)	Length in (mm)	Amp	
		F	V&OH
5/64 (2.0)	9.8 (250)	40-50	35-45
3/32 (2.4)	11.8 (300)	50-70	40-60
1/8 (3.2)	13.8 (350)	80-120	70-90
5/32 (4.0)	13.8 (350)	110-140	90-130
3/16 (5.0)	13.8 (350)	140-170	-

Packaging

10# (5 kg) Carton

Detailed Packaging Information

Welding Positions

All Welding Positions

Approved

ABS, BV, CWB, GL, KR, LR, TUV

AWS E317L-16

KST-317-16

Welding of AISI(SUS)317. Welding of dissimilar steels such as carbon steel to stainless steels.

1. Good weldability and performance.
2. Reduced susceptibility of pitting.

Carbon	0.06 %
Silicon	0.74 %
Manganese	1.20 %
Chromium	18.5 %
Nickel	12.3 %
Molybdenum	3.2 %

T-S (psi)	84,122
EI	42%
5% H ₂ SO ₄	4.6 g/m ² · hr

Dia in (mm)	Length in (mm)	Amp	
		F	V&OH
5/64 (2.0)	9.8 (250)	40-50	35-45
3/32 (2.4)	11.8 (300)	55-90	45-60
1/8 (3.2)	13.8 (350)	80-110	70-90
5/32 (4.0)	13.8 (350)	110-150	90-130
3/16 (5.0)	13.8 (350)	140-180	-

10# (5 kg) Carton

Detailed Packaging Information

All Welding Positions

Stainless Steel

AWS E317L-16

KST-317L-16

Welding of low carbon 18%Cr-12%Ni-3%Mo which requires excellent corrosion resistance to sulfuric acid and solutions containing these salts.

1. Good weldability and performance.
2. Reduced susceptibility of pitting.

Carbon	0.03 %
Silicon	0.75 %
Manganese	1.24 %
Chromium	18.6 %
Nickel	12.4 %
Molybdenum	3.3 %

T-S (psi)	81,221
EI	44%
5% H ₂ SO ₄	4.0 g/m ² · hr

Dia in (mm)	Length in (mm)	Amp	
		F	V&OH
5/64 (2.0)	9.8 (250)	40-60	35-45
3/32 (2.4)	11.8 (300)	55-80	40-60
1/8 (3.2)	13.8 (350)	80-110	70-90
5/32 (4.0)	13.8 (350)	110-150	90-130
3/16 (5.0)	13.8 (350)	140-180	-

10# (5 kg) Carton

Detailed Packaging Information

All Welding Positions



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Covered Electrodes

AWS E318-16

KST-318-16

Typical Applications

Welding of AISI 318, 316, 316L stainless steel.

Characteristics Of Usage

1. The deposited weld metal is highly resistant to pitting and general types of corrosion.
2. Highly resistant to intergranular corrosion due to the addition of Nb.

Weld Metal Composition

Carbon	0.05 %
Silicon	0.76 %
Manganese	1.32 %
Chromium	18.5 %
Nickel	11.9 %
Molybdenum	2.3 %

Mechanical Properties

T-S (psi)	91,374
EI	38 %
40 % HNO ₃	0.08 g/m ² · hr

Available Sizes / Rec. Parameters

Dia in (mm)	Length in (mm)	Amp	
		F	V&OH
5/64 (2.0)	9.8 (250)	40-60	35-45
3/32 (2.4)	11.8 (300)	50-80	45-60
1/8 (3.2)	13.8 (350)	80-110	60-90
5/32 (4.0)	13.8 (350)	120-150	90-130
3/16 (5.0)	13.8 (350)	140-180	-

Packaging

10# (5 kg) Carton

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Welding Positions

All Welding Positions

Approved

AWS E347-16

KST-347-16

Welding of AISI(SUS)304L, 321, 347 stainless steel and the place where heat treatment after welding is not possible.

1. Excellent intergranular corrosion resistance.

Carbon	0.06 %
Silicon	0.42 %
Manganese	1.98 %
Chromium	19.9 %
Nickel	9.5 %
Molybdenum	0.6 %

T-S (psi)	91,374
EI	36 %
40 % HNO ₃	0.08 g/m ² · hr

Dia in (mm)	Length in (mm)	Amp	
		F	V&OH
5/64 (2.0)	9.8 (250)	40-60	35-45
3/32 (2.4)	11.8 (300)	50-70	45-60
1/8 (3.2)	13.8 (350)	70-110	65-90
5/32 (4.0)	13.8 (350)	100-150	90-130
3/16 (5.0)	13.8 (350)	140-180	-

10# (5 kg) Carton

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All Welding Positions

Stainless Steel

AWS E347L-16

KST-347L-16

Welding of low carbon AISI(SUS)304L, 321, 347 stainless steel and the place where heat treatment after welding is not possible.

1. Excellent intergranular corrosion resistance.

Carbon	0.03 %
Silicon	0.46 %
Manganese	1.68 %
Chromium	19.4 %
Nickel	9.8 %
Niobium	0.7 %

T-S (psi)	88,473
EI	36 %
40 % HNO ₃	0.08 g/m ² · hr

Dia in (mm)	Length in (mm)	Amp	
		F	V&OH
5/64 (2.0)	9.8 (250)	40-60	35-45
3/32 (2.4)	11.8 (300)	55-80	45-60
1/8 (3.2)	13.8 (350)	80-110	70-90
5/32 (4.0)	13.8 (350)	110-140	90-130
3/16 (5.0)	13.8 (350)	140 -170	-

10# (5 kg) Carton

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All Welding Positions



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Covered Electrodes

AWS E410-16

KST-410-16

AWS E430-16

KST-430-16

Stainless Steel

Typical Applications

Welding of 13%Cr steel and surfacing of the part where cavitation or corrosion resistance is required.

Welding of 17%Cr stainless steel.
Welding of AISI(SUS)403, 405

Characteristics Of Usage

1. Excellent oxidation corrosion and abrasion resistance of the deposited weld metal.
2. Preheat at 212-392°F and postheat treat at 1292-1472°F due to self-hardening.

1. Preheat at 392-572°F and postheat treat at 1292-1472°F.

Weld Metal Composition

Carbon	0.08 %
Silicon	0.70 %
Manganese	0.76 %
Chromium	12.1 %

Carbon	0.07 %
Silicon	0.42 %
Manganese	0.40 %
Chromium	17.4 %

Mechanical Properties

T-S (psi)	81,221
EI	24 %
PWHT	1346 °F x 1 hr S-R

T-S (psi)	76,870
EI	31 %
PWHT	1400°F x 1 hr S-R

Available Sizes / Rec. Parameters

Dia in (mm)	Length in (mm)	Amp F	V&OH
3/32 (2.4)	11.8 (300)	60-90	45-60
1/8 (3.2)	13.8 (350)	80-110	70-90
5/32 (4.0)	13.8 (350)	110-150	90-130
3/16 (5.0)	13.8 (350)	150-180	-

Dia in (mm)	Length in (mm)	Amp F	V&OH
3/32 (2.4)	11.8 (300)	55-70	45-60
1/8 (3.2)	13.8 (350)	80-100	70-90
5/32 (4.0)	13.8 (350)	110-140	90-130
3/16 (5.0)	13.8 (350)	140-170	-

Packaging

10# (5 kg) Carton

10# (5 kg) Carton

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Welding Positions

All Welding Positions

All Welding Positions

Approved



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Tubular Wires

Mild Steel
Self-Shielded
Metal Cored
Stainless Steel



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Tubular Wires

AWS E70T-1

K-70T

Typical Applications

Designed for welding of 71 ksi high tensile steel with outstanding mechanical properties. Typical applications include machinery, shipbuilding, offshore structures, bridges and general fabrications.

Characteristics Of Usage

1. Flux cored wire designed for flat and horizontal position welding.
2. Excellent deposition rate.
3. Provides smooth arc, low spatter levels, good bead appearance.
4. 100%CO₂ or Ar+20-25%CO₂ shielding gas should be used.

Weld Metal Composition

SG	CO ₂
Carbon	0.03 %
Silicon	0.50 %
Manganese	1.45 %
Phosphorus	0.014 %
Sulphur	0.013 %

Mechanical Properties

Y-P (psi)	78,320
T-S (psi)	82,672
EI	25 %
V-notch	48 ft/lb @ -4 °F

Available Sizes / Rec. Parameters

Dia in (mm)	F	Amp H-Fil
.045	140-340	140-340
(1.2)	200-460	200-460
1/16		
(1.6)		
5/64 (2.0)		
3/32 (2.4)		

Packaging

Detailed Packaging Information

Welding Positions

Flat and Horizontal

Approved

JIS, KS

AWS E70T-5M

K-70TB

Designed for welding of 71 ksi high tensile steel with only Ar/CO₂ mixtures. Typical application is general fabrication where the risk of hydrogen-induced cracking is to be avoided.

1. For flat and horizontal position welding.
2. Good fracture toughness at low temperatures with low susceptibility to cracking.
3. Soft, smooth welding arc with low spatter levels.
4. Use Ar+20-25%CO₂ shielding gas.

SG	Ar+20%CO ₂
Carbon	0.04 %
Silicon	0.34 %
Manganese	1.30 %
Phosphorus	0.016 %
Sulphur	0.013 %

Y-P (psi)	71,068
T-S (psi)	79,771
EI	29 %
V-notch	50 ft/lb @ -22 °F

Dia in (mm)	F	Amp H-Fil
.045 (1.2)	120 - 300	120 - 300
1/16 (1.6)	200 - 450	200 - 450
3/32 (2.4)		

Detailed Packaging Information

Flat and Horizontal

Mild Steel

AWS E70T-1C/1M, 9C/9M

K-70ST

K-70ST is designed for welding of 70,000 psi tensile steel with outstanding mechanical properties. It is most suitable for fillet welding of inorganic zinc-primer coated steels often used in the machinery, steel fabrication and construction industries.

1. Titania type of flux cored wire for flat and horizontal position welding.
2. Efficient due to higher deposition rates.
3. Arc characteristics are smooth and stable.
4. Use with 100% CO₂ or Ar+20-25%CO₂.

SG	CO ₂
Carbon	0.04 %
Silicon	0.49 %
Manganese	1.36 %
Phosphorus	0.015 %
Sulphur	0.013 %

Y-P (psi)	68,000
T-S (psi)	80,000
EI	28 %
V-notch	100 ft/lb @ -22 °F

Dia in (mm)	F	Amp H-Fil
.045 (1.2)	140-300	160-300
.052 (1.4)	160-380	180-360
1/16 (1.6)	180-420	220-400

Detailed Packaging Information

Flat and Horizontal

ABS,BV, DNV,GL, LR



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Tubular Wires

AWS E70T-1C/1M, 9C/9M

KX-200H

Typical Applications

Designed for welding of 70,000 psi tensile steel with outstanding mechanical properties. Typical applications include machinery, shipbuilding, offshore structures, bridges and general fabrication.

Characteristics Of Usage

1. Designed for flat and horizontal position welding.
2. Better CVN toughness at lower temp.
3. Good porosity resistance and used for fillet welding of inorganic zinc-primer coated steels.
4. For semi-automatic, automatic, single- and multiple pass welding.

Weld Metal Composition

SG	CO ₂
Carbon	0.037 %
Silicon	0.56 %
Manganese	1.60 %
Phosphorus	0.013 %
Sulphur	0.012 %

Mechanical Properties

Y-P (psi)	73,000
T-S (psi)	84,000
EI	28 %
V-notch	68 ft/lb @ -22 °F

Available Sizes / Rec. Parameters

Dia in (mm)	F	Amp H-Fil
.045 (1.2)	140-300	160-300
.052 (1.4)	160-380	180-360
1/16 (1.6)	180-420	220-400

Packaging

Detailed Packaging Information

Welding Positions

Flat and Horizontal

Approved

ABS, KR, DNV, GL, LR

AWS E71T-1/1M

K-71TLF

Formulated for welding of 71 ksi high tensile steel with outstanding mechanical properties. Typical applications include machinery, shipbuilding, offshore structures, bridges and general fabrications.

1. Titania type for all-position welding.
2. Low fume generation, good impact strength at low temperatures.
3. Stable arc, less spatter levels, better bead appearance.
4. 100%CO₂ shielding gas should be used.

SG	CO ₂
Carbon	0.03 %
Silicon	0.38 %
Manganese	1.35 %
Phosphorus	0.015 %
Sulphur	0.010 %

Y-P (psi)	75,420
T-S (psi)	82,672
EI	28 %
V-notch	59 ft/lb @ -4 °F

Dia in (mm)	F	Amp H	V
.045 (1.2)	120-300	120-300	120-220
1/16 (1.6)	200-450	200-400	180-220

Detailed Packaging Information

Flat, Horizontal, Vertical, Overhead and Vertical Down

ABS, BV, CCS, DNV, GL, KR, LR, NK, RINA, TUV, JIS, KS

Mild Steel

AWS E71T-1M

K-71TM

Designed for welding of 71 ksi high tensile steel with only Ar/CO₂ mixtures. Typical applications include machinery, shipbuilding, offshore structures, bridges and general fabrications.

1. Titania type for all-position welding.
2. It provides soft, smooth welding arc with less spatter levels.
3. Efficient welding with deposition rates.
4. Ar+20-25%CO₂ should be used.

SG	Ar+20 % CO ₂
Carbon	0.03 %
Silicon	0.59 %
Manganese	1.44 %
Phosphorus	0.013 %
Sulphur	0.014 %

Y-P (psi)	72,519
T-S (psi)	75,420
EI	28 %
V-notch	59 ft/lb @ -4 °F

Dia in (mm)	F	Amp H-Fil	V
.045 (1.2)	120-300	120-300	120-220
1/16 (1.6)	200-450	200-450	180-240

Detailed Packaging Information

Flat, Horizontal, Vertical, Overhead and Vertical Down

ABS, BV, DNV, LR, RINA, TUV, JIS, KS



KISWEL
WELDING PRODUCTS

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Tubular Wires

AWS E71T-1C/1M, 9C/9M

K-71T Plus

Typical Applications

Formulated for welding of 70,000 psi tensile steel for use with both CO₂ or Ar/CO₂ gas properties. Typical applications include machinery, shipbuilding, offshore structures, bridges and general fabrication.

Characteristics Of Usage

1. This is a titania type flux cored wire for all position welding.
2. It provides excellent feedability and soft welding arc, as well as less spatter generation.
3. Provides low fume generation and has good toughness at low temperatures.

Weld Metal Composition

SG	CO ₂
Carbon	0.03 %
Silicon	0.40 %
Manganese	1.20 %
Phosphorus	0.015 %
Sulphur	0.012 %

Mechanical Properties

Y-P (psi)	77,000
T-S (psi)	83,000
EI	28 %
V-notch	74 ft/lb @ -22 °F

Available Sizes / Rec. Parameters

Dia in (mm)	F	Amp	
		H	V
.035 (.9)	100-240	120-220	120-160
.045 (1.2)	120-300	140-260	160-240
1/16 (1.6)	180-400	200-360	180-260

Packaging

[Detailed Packaging Information](#)

Welding Positions

All Positions

Approved

AWS E71T-1C/1M, 12C/12M

K-71TP

This wire is designed for low temp. impact properties. It can be used in a variety of applications including shipbuilding, pressure vessels, bridges and the construction industries. Ar+20-25%CO₂ gases should be used.

1. Titania type for all-position welding.
2. For 70,000 psi tensile strength steels.
3. Provides improved impact toughness and lower Mn content required in ASME Boiler and Pressure Vessel Code, Section IX.
4. It has easy slag removal, good weld soundness, and low spatter.

SG	CO ₂
Carbon	0.025 %
Silicon	0.43 %
Manganese	1.12 %
Phosphorus	0.011 %
Sulphur	0.011 %

Y-P (psi)	78,000
T-S (psi)	83,000
EI	28 %
V-notch	74 ft/lb @ -22 °F

Dia in (mm)	F	Amp	
		H	V
.035 (.9)	100-240	120-220	120-160
.045 (1.2)	120-300	140-260	160-240
1/16 (1.6)	180-400	200-360	180-260

[Detailed Packaging Information](#)

All Positions



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Mild Steel

Tubular Wires

AWS E71T-11

K-NGS11

Self Shielded

Typical Applications

Self-shielded flux cored wire for lap and fillet welds of mild and medium tensile steels not exceeding 74 ksi. Suitable for prefab, building fabrication, tanks, ornamental iron, farm equipment, repairs and general fabrication.

Characteristics Of Usage

1. Wire is for all position welding of single and multiple pass fabrications.
2. Welding arc is smooth and stable.
3. It is designed for on site general fabrication and structural work requiring no impact properties.
4. Designed for use with DCEN.

Weld Metal Composition

Carbon	0.10 %
Silicon	0.10 %
Manganese	0.55 %
Phosphorus	0.016 %
Sulphur	0.006 %
Aluminum	1.2 %

Mechanical Properties

Y-P (psi)	72,519
T-S (psi)	76,870
EI	23 %

Available Sizes / Rec. Parameters

Dia in (mm)	Amp F
.045 (1.2)	80-200
1/16 (1.6)	160-270
5/64 (2.0)	180-280

Packaging

[Detailed Packaging Information](#)

Welding Positions

All Welding Positions

Approved



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Tubular Wires AWS E70C-3M **KX-70CM**

AWS E70C-3C **KX-100**

Metal Cored AWS E70C-6M **KX-706M**

Typical Applications

Designed for welding of 71 ksi high tensile steel with only Ar/CO₂ mixtures. It is especially suitable for fillet welding and has a high tolerance to primer.

Typical applications include machinery, shipbuilding, offshore structures, bridges and general fabrications.

Designed for welding of 71 ksi high tensile steel with only Ar/CO₂ mixtures. It is especially suitable for fillet welding and has a high tolerance to primer.

Characteristics Of Usage

1. For flat and horizontal position welding.*
2. Multiple pass welding can be performed without removing slag.
3. Can have higher productivity compared to solid wires.
4. Semi-automatic, automatic, single and multiple pass welding.

1. Wire is a metal type of flux cored wire for flat and horizontal position welding.*
2. Deposition can be higher than solid wires.
3. Multiple pass welding can be performed without removing slag.
4. 100%CO₂ shielding gas should be used.

1. For flat and horizontal position welding.*
2. Good CVN toughness at low temp.
3. Good penetration with excellent wetting characteristics. Higher tolerance to rust/mill scale compared to E70C-3 grade.
4. Intended for semi-automatic, automatic, single/multiple pass welding.

Weld Metal Composition

SG	Ar+20 % CO ₂
Carbon	0.03 %
Silicon	0.40 %
Manganese	1.60 %
Phosphorus	0.014 %
Sulphur	0.013 %

SG	CO ₂
Carbon	0.04 %
Silicon	0.54 %
Manganese	1.55 %
Phosphorus	0.014 %
Sulphur	0.011 %

SG	Ar+20 % CO ₂
Carbon	0.04 %
Silicon	0.60 %
Manganese	1.50 %
Phosphorus	0.014 %
Sulphur	0.013 %

Mechanical Properties

Y-P (psi)	69,618
T-S (psi)	78,320
EI	29 %
V-notch	41 ft/lb @ -4 °F

Y-P (psi)	73,969
T-S (psi)	79,771
EI	29 %
V-notch	44 ft/lb @ -4 °F

Y-P (psi)	76,870
T-S (psi)	88,473
EI	27 %
V-notch	41 ft/lb @ -4 °F

Available Sizes / Rec. Parameters

Dia in (mm)	F/H-Fil	Amp V
.045 (1.2)	160-340	180-350
.052 (1.4)	180-420	220-380
1/16 (1.6)	240-450	280-450

Dia in (mm)	Amp F/H-Fil
.045 (1.2)	140-340
1/16 (1.6)	200-460

Dia in (mm)	Amp F	Amp H
.045 (1.2)	160-350	180-360
.052 (1.4)	160-380	180-360
1/16 (1.6)	180-360	280-450

.045" (1.2 mm) x 33# (15 kg) spool
1/16" (1.6 mm) x 33# (15 kg) spool

Detailed Packaging Information

Detailed Packaging Information

Detailed Packaging Information

Welding Positions

Flat and Horizontal
* Can be used in all position welding when using appropriate pulsed welding equipment

Flat and Horizontal
* Can be used in all position welding when using appropriate pulsed welding equipment

Flat and Horizontal
* Can be used in all position welding when using appropriate pulsed welding equipment

Approved

ABS, BV, DNV, GL, JIS, KS, LR, RINA
(80%Ar + 20%CO₂ TUV)

ABS, BV, DNV, GL, JIS, KR, KS, LR, NK

ABS, BV, DNV, GL, JIS, KS, LR, RINA, CWB
(Ar + 2-20%CO₂)



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Tubular Wires

AWS E70C-6M

KX-706M Plus

Metal Cored

Typical Applications

KX-706M Plus is designed for welding of 70,000 psi tensile steel with only Ar/CO₂ gas mixtures. It is especially suitable for fillet welding and has a high tolerance to primer. Typical applications include machinery, shipbuilding, offshore structures, bridges and fabrication.

Characteristics Of Usage

1. Provides excellent feedability and good penetration, high resistance to porosity, good wetting action and low hydrogen.
2. Slag content generation is same as a solid wire and is a multiple pass wire that can be used without removing slag.
3. Can be used semi-automatically, automatically, single- and multiple pass.

Weld Metal Composition

SG	Ar+20 % CO ₂
Carbon	0.04 %
Silicon	0.45 %
Manganese	1.45 %
Phosphorus	0.014 %
Sulphur	0.013 %

Mechanical Properties

Y-P (psi)	73,000
T-S (psi)	83,000
EI	27 %
V-notch	60 ft/lb @ -22 °F

Available Sizes / Rec. Parameters

Dia in (mm)	Amp	
	F	H
.045 (1.2)	140-300	160-300
.052 (1.4)	160-380	180-360
1/16 (1.6)	180-400	220-380

Packaging

[Detailed Packaging Information](#)

Welding Positions

Flat and Horizontal

Approved



KISWEL
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Tubular Wires

AWS E308LT0-1 / -4

K-308LT0

Typical Applications

Designed for MAG welding of low carbon 18%Cr-8%Ni stainless steel and used to join 301, 302, 304 and 308 stainless steel. It is designed for operation primarily in the flat position and for welding horizontal fillet welds.

Characteristics Of Usage

1. Titania type flux core with self detaching slag with a spray-like transfer.
2. Low spatter, high efficiency with optimized ferrite for good resistance to crack susceptibility.
3. Can be used with both 100% CO₂ and 80%Ar+20%CO₂.

Weld Metal Composition

SG	CO ₂	Ar+20 % CO ₂
Carbon	0.03 %	0.03 %
Silicon	0.52 %	0.70 %
Manganese	1.70 %	1.80 %
Chromium	20.3 %	20.5 %
Nickel	10.4 %	10.5 %

Mechanical Properties

SG	CO ₂	Ar+20 % CO ₂
T-S (psi)	89,923	91,374
EI	38 %	36 %

Available Sizes / Rec. Parameters

Dia in (mm)	Electrode Extension	Amp
.045 (1.2)	.39" - .79"	100-220
1/16 (1.6)	.59" - .98"	160-260

Packaging

.045" (1.2 mm) x 33# (15 kg) spool
1/16" (1.6 mm) x 33# (15 kg) spool

Detailed Packaging Information

Welding Positions

Flat, Horizontal Fillets and Groove Welds

Approved

JIS

AWS E308LT1-1/-4

K-308LT

Designed for MAG welding of low carbon 18%Cr-8%Ni stainless steels. (AISI 304, 304L, 304LN, ASTM A157 Gr. C9; A320 Gr. B8C or D)

1. Titania type flux core with self detaching slag with a spray-like transfer.
2. Low spatter, high efficiency with optimized ferrite for good resistance to crack susceptibility.
3. Can be used with both 100% CO₂ and 80%Ar+20%CO₂.

SG	CO ₂	Ar+20 % CO ₂
Carbon	0.03 %	0.03 %
Silicon	0.62 %	0.79 %
Manganese	1.56 %	1.90 %
Chromium	19.5 %	19.8 %
Nickel	10.5 %	10.2 %

SG	CO ₂	Ar+20 % CO ₂
T-S (psi)	82,672	88,473
EI	38 %	35 %

Dia in (mm)	Electrode Extension	Amp
.045 (1.2)	.39" - .79"	100-220
1/16 (1.6)	.59" - .98"	160-260

.045" (1.2 mm) x 33# (15 kg) spool
1/16" (1.6 mm) x 33# (15 kg) spool

Detailed Packaging Information

Flat, Horizontal, Overhead, Vertical Down

ABS, BV, CWB, KR, NK, TUV, JIS
(80%Ar + 20%CO₂ : CWB, TUV)

Call Customer Service
For Availability: 1.877.754.7935

Stainless Steel

AWS E308T0-1/-4

K-308T

K-308T is formulated for MAG welding of 18%Cr-8%Ni stainless steels. It is designed for operation primarily in the flat position and for welding horizontal fillet welds.

1. Titania type flux core with self detaching slag with a spray-like transfer.
2. Low spatter, high efficiency with optimized ferrite for good resistance to crack susceptibility.
3. Can be used with both 100% CO₂ and 80%Ar+20%CO₂.

SG	CO ₂	Ar+20 % CO ₂
Carbon	0.05 %	0.04 %
Silicon	0.60 %	0.75 %
Manganese	1.55 %	1.87 %
Chromium	19.5 %	19.7 %
Nickel	10.5 %	10.3 %

SG	CO ₂	Ar+20 % CO ₂
T-S (psi)	84,122	88,473
EI	38 %	36 %

Dia in (mm)	Electrode Extension	Amp
.045 (1.2)	.39" - .79"	100-220
1/16 (1.6)	.59" - .98"	160-260

.045" (1.2 mm) x 33# (15 kg) spool
1/16" (1.6 mm) x 33# (15 kg) spool

Detailed Packaging Information

Flat, Horizontal Fillet and Groove Welds

ABS, BV, DNV, JIS, KR, NK



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Tubular Wires

AWS E309LT0-1 /-4

K-309LT0

AWS EC309L

K-309LMT

Stainless Steel

AWS E309LT1-1/-4

K-309LT1

Typical Applications

Designed for MAG welding of low carbon 22%Cr-12%Ni stainless steel. Dissimilar joint welds. Cladding for corrosion resistant weld claddings on ferritic-perlitic steels in boiler and pressure vessel parts up to finegrained steel S500N.

Designed for MAG welding of low carbon 22%Cr-12%Ni stainless steels. It is suitable for automotive exhaust fabricators such as front pipe, bellows, flange. (AISI 409, 436, cladding and dissimilar joint welds).

Designed for low carbon 22%Cr-12%Ni stainless steels. Dissimilar joint welds. Cladding for the first layer of corrosion resistant weld claddings on ferritic-perlitic steels in boiler and pressure vessel parts up to fine-grained steel S500N.

Characteristics Of Usage

1. Designed for use on most carbon steels to type 304 stainless steels.
2. Increased Cr and Ni levels provide good resistance to cracking.
3. Not recommended for use above 750°F.

1. Designed for welding most mild steels to austenitic stainless alloys
2. Increased Cr and Ni provides improved resistance to cracking
3. Not intended for use above 750°F.

1. Designed for welding most mild steels to austenitic stainless alloys
2. Increased Cr and Ni provides improved resistance to cracking
3. Not intended for use above 750°F.

Weld Metal Composition

SG	CO ₂	Ar+20 % CO ₂
Carbon	0.03 %	0.03 %
Silicon	0.65 %	0.72 %
Manganese	1.55 %	1.60 %
Chromium	24.0 %	24.2 %
Nickel	13.2 %	13.3 %

SG	Ar+2 % CO ₂
Carbon	0.03 %
Silicon	0.48 %
Manganese	1.57 %
Chromium	23.9 %
Nickel	12.4 %

SG	CO ₂	Ar+20 % CO ₂
Carbon	0.03 %	0.03 %
Silicon	0.60 %	0.80 %
Manganese	1.40 %	1.92 %
Chromium	23.6 %	23.8 %
Nickel	13.1 %	13.3 %

Mechanical Properties

SG	CO ₂	Ar+20 % CO ₂
T-S (psi)	91,374	92,824
EI	40 %	38 %

SG	Ar+2 % CO ₂
T-S (psi)	81,221
EI	40 %

SG	CO ₂	Ar+20 % CO ₂
T-S (psi)	79,771	87,023
EI	40 %	38 %

Available Sizes / Rec. Parameters

Dia in (mm)	Electrode Extension	Amp
.045 (1.2)	.39" - .79"	100-220
1/16 (1.6)	.59" - .98"	160-260

Dia in (mm)	Electrode Extension	Amp
.045 (1.2)	.39" - .79"	140-220
1/16 (1.6)	.59" - .98"	180-260

Dia in (mm)	Electrode Extension	Amp
.045 (1.2)	.39" - .79"	100-220
1/16 (1.6)	.59" - .98"	160-260

Packaging

.045" (1.2 mm) x 33# (15 kg) spool
1/16" (1.6 mm) x 33# (15 kg) spool

Detailed Packaging Information

.045" (1.2 mm) x 33# (15 kg) spool
1/16" (1.6 mm) x 33# (15 kg) spool

Detailed Packaging Information

.045" (1.2 mm) x 33# (15 kg) spool
1/16" (1.6 mm) x 33# (15 kg) spool

Detailed Packaging Information

Welding Positions

Flat, Horizontal Fillets and Groove Welds

Flat, Horizontal Fillets and Groove Welds

Flat, Vertical and Overhead

Approved

JIS

KR, JIS



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WELDING PRODUCTS

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Tubular Wires

AWS E309LMoT1-1

K-309MoLT

Typical Applications

Designed for low carbon 22%Cr - 12%Ni-Mo. Dissimilar joint welds. Cladding for the first layer of corrosion resistant weld claddings on ferritic/perlitic steels in boiler and pressure vessel parts up to fine-grained steel S500N.

Characteristics Of Usage

1. Provide better weldability with superior heat resistance and corrosion resistance.
2. Higher tensile strength when compared to conventional K-309LT wire.
3. For Mo-alloyed claddings the product is necessary for the first layer.

Weld Metal Composition

SG	CO ₂
Carbon	0.03 %
Silicon	0.54 %
Manganese	1.30 %
Chromium	23.7 %
Nickel	13.0 %
Molybdenum	2.7 %

Mechanical Properties

SG	CO ₂
T-S (psi)	97,175
EI	32 %

Available Sizes / Rec. Parameters

Dia in (mm)	Electrode Extension	Amp
.045 (1.2)	.39" - .79"	100-220
1/16 (1.6)	.59" - .98"	160-260

Packaging

.045" (1.2 mm) x 33# (15 kg) spool
1/16" (1.6 mm) x 33# (15 kg) spool

Detailed Packaging Information

Welding Positions

Flat, Horizontal, Overhead, Vertical Down

Approved

KR, JIS

AWS E309T0-1/-4

K-309T

Formulated for MAG welding of 22%Cr-12%Ni stainless steels. Typical applications are for welding of dissimilar steels, such as 304 to mild steel or low alloy steels.

1. Designed primarily for flat and horizontal welding applications.
2. Better weldability, superior heat resistance and corrosion resistance.

SG	CO ₂	Ar+20%CO ₂
Carbon	0.05 %	0.04 %
Silicon	0.58 %	0.78 %
Manganese	1.45 %	1.93 %
Chromium	23.5 %	23.7 %
Nickel	13.0 %	13.4 %

SG	CO ₂	Ar+20 % CO ₂
T-S (psi)	85,572	88,473
EI	36 %	35 %

Dia in (mm)	Electrode Extension	Amp
.045 (1.2)	.39" - .79"	100-220
1/16 (1.6)	.59" - .98"	160-260

.045" (1.2 mm) x 33# (15 kg) spool
1/16" (1.6 mm) x 33# (15 kg) spool

Detailed Packaging Information

Flat, Horizontal Fillets and Groove Welds

ABS, BV, DNV, KR, LR, NK, JIS

Stainless Steel

AWS E312T1-1

K-312T

Formulated for MAG welding of 30%Cr-9%Ni stainless steels. It is used for joining dissimilar steels, steels with reduced weldability and buffer layers prior to hardfacing (rolls, forging dies, hotwork tools and dies for plastics).

1. Good resistance to stress corrosion attack and reduced scaling at temperatures up to 2100 °F.
2. Excellent usability with stable arc, less spatter levels, better bead appearance.

SG	CO ₂
Carbon	0.04 %
Silicon	0.83 %
Manganese	1.00 %
Chromium	30.2 %
Nickel	9.5 %

SG	CO ₂
T-S (psi)	110,229
EI	25 %

Dia in (mm)	F	Amp H	V
.045 (1.2)	100-240A	100-240A	140-200
1/16 (1.6)	160-260A	160-380A	180-240

.045" (1.2 mm) x 33# (15 kg) spool
1/16" (1.6 mm) x 33# (15 kg) spool

Detailed Packaging Information

Flat, Horizontal, Overhead, Vertical Down

JIS



KISWEL
WELDING PRODUCTS

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Tubular Wires

AWS E316LTO-1/-4

K-316LT0

Typical Applications

Designed for MAG welding of low carbon 18%Cr-12%Ni-2%Mo stainless steel. Low carbon content which gives good resistance to most types of corrosion of the weld metal.

Characteristics Of Usage

1. Designed for applications where pitting corrosion is evident as found in pulp and paper mills
2. Increased creep resistance at elevated temperature.

Weld Metal Composition

SG	CO ₂	Ar+20 % CO ₂
Carbon	0.03 %	0.03 %
Silicon	0.65 %	0.70 %
Manganese	1.58 %	1.62 %
Chromium	19.4 %	19.2 %
Nickel	12.4 %	12.8 %
Molybdenum	2.42 %	2.50 %

Mechanical Properties

SG	CO ₂	Ar+20 % CO ₂
T-S (psi)	87,023	89,923
EI	39 %	38 %

Available Sizes / Rec. Parameters

Dia in (mm)	Electrode Extension	Amp
.045 (1.2)	.39" - .79"	100-220
1/16 (1.6)	.59" - .98"	160-260

Packaging

.045" (1.2 mm) x 33# (15 kg) spool
1/16" (1.6 mm) x 33# (15 kg) spool

Detailed Packaging Information

Welding Positions

Flat, Horizontal Fillets and Groove Welds

Approved

JIS

AWS E316LTI -1 /-4

K-316LT1

Designed for MAG welding of low carbon 18%Cr-12%Ni-2%Mo stainless steels. Low carbon content gives good resistance to most types of corrosion of the weld metal (AISI 316L, 316Ti, 316Cb)

1. Designed for welding type 316L stainless. Addition of Mo resists pitting corrosion typically brought on by sulphuric and sulphurous acids
2. Weldability is excellent with lower crack susceptibility.

SG	CO ₂	Ar+20 % CO ₂
Carbon	0.03 %	0.03 %
Silicon	0.65 %	0.75 %
Manganese	1.20 %	1.85 %
Chromium	18.3 %	18.7 %
Nickel	12.2 %	11.4 %
Molybdenum	2.8 %	2.5 %

SG	CO ₂	Ar+20 % CO ₂
T-S (psi)	79,771	89,923
EI	40 %	38 %

Dia in (mm)	Electrode Extension	Amp
.045 (1.2)	.39" - .79"	100-240
1/16 (1.6)	.59" - .98"	160-260

.045" (1.2 mm) x 33# (15 kg) spool
1/16" (1.6 mm) x 33# (15 kg) spool

Detailed Packaging Information

Flat, Horizontal, Overhead, Vertical Down

ABS, BV, CWB, DNV, KR, NK, RINA, TUV, JIS
(80%Ar + 20%CO₂ : CWB, TUV)

Call Customer Service
For Availability: 1.877.754.7935

Stainless Steel

AWS E316T0-1 / -4

K-316T

Formulated for MAG welding of 18%Cr-12%Ni-2%Mo stainless steels where increased resistance to pitting corrosion is required (AISI 316, 316L)

1. Low spatter, easy slag removal and good weld soundness.
2. Weldability is excellent with lower crack susceptibility.

SG	CO ₂	Ar+20 % CO ₂
Carbon	0.05 %	0.04 %
Silicon	0.60 %	0.76 %
Manganese	1.47 %	1.82 %
Chromium	18.4 %	18.6 %
Nickel	12.0 %	11.5 %
Molybdenum	2.5 %	2.5 %

SG	CO ₂	Ar+20 % CO ₂
T-S (psi)	84,122	88,473
EI	38 %	37 %

Dia in (mm)	Electrode Extension	Amp
.045 (1.2)	.39" - .79"	100-240
1/16 (1.6)	.59" - .98"	160-260

.045" (1.2 mm) x 33# (15 kg) spool
1/16" (1.6 mm) x 33# (15 kg) spool

Detailed Packaging Information

Flat, Horizontal Fillets and Groove Welds

ABS, KR, JIS



KISWEL
WELDING PRODUCTS

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SEARCH

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Tubular Wires

AWS E317LT1-1

K-317LT

Typical Applications

Designed for MAG welding of low carbon 19%Cr-13%Ni-3%Mo stainless steels. The principal area of application is process and chemical plant, shipbuilding as well as nuclear plant industries. (AISI 316L, 316LN, 317L, 317LN, UNS S31726).

Characteristics Of Usage

1. Self-detaching slag, spray-like arc transfer, excellent weldability and increased creep resistance at elevated temperature.
2. Higher levels of Mo for increased corrosion-resistance.
3. Lower crack susceptibility.

Weld Metal Composition

SG	CO ₂
Carbon	0.03 %
Silicon	0.65 %
Manganese	1.25 %
Chromium	18.8 %
Nickel	13.7 %
Molybdenum	3.5 %

Mechanical Properties

SG	CO ₂
T-S (psi)	88,473
EI	33 %

Available Sizes / Rec. Parameters

Dia in (mm)	Electrode Extension	Amp
.045 (1.2)	.39" - .79"	100-240
1/16 (1.6)	.59" - .98"	160-260

Packaging

.045" (1.2 mm) x 33# (15 kg) spool
1/16" (1.6 mm) x 33# (15 kg) spool

Detailed Packaging Information

Welding Positions

Flat, Horizontal, Overhead, Vertical Down

Approved

ABS, JIS

AWS E2209T1-1 /-4

K-329T

Formulated for MAG welding of 23%Cr-9%Ni-3%Mo duplex stainless steels. Applications are chemical plant and shipbuilding as well as nuclear plant industries. (ASTM A185 Gr.51, UNS 531803, DIN 1.4462, JIS 329,11)

1. Produces a weld with easy slag removal and minimal spatter.
2. Excellent in pitting corrosion resistance and stress corrosion cracking resistance.

SG	CO ₂	Ar+20 % CO ₂
Carbon	0.03 %	0.03 %
Silicon	0.49 %	0.62 %
Manganese	1.67 %	1.83 %
Chromium	23.1 %	23.3 %
Nickel	9.6 %	9.5 %
Molybdenum	2.8 %	2.8 %

SG	CO ₂	Ar+20 % CO ₂
T-S (psi)	118,351	119,366
EI	27 %	27 %

Dia in (mm)	F	Amp H	V
.045 (1.2)	100-240	100-240	120-200
1/16 (1.6)	160-260	160-260	160-220

.045" (1.2 mm) x 33# (15 kg) spool
1/16" (1.6 mm) x 33# (15 kg) spool

Detailed Packaging Information

Flat, Horizontal, Overhead, Vertical Down

ABS, JIS

Stainless Steel

AWS E347T1-1

K-347T

Formulated for MAG welding of 18%Cr-8%Ni-Nb stainless steels. (AISI 347, 321, ASTM A296; A157 Gr. C9; A320 Gr. B8C or D)

1. Wire has low spatter, easy slag removal and good weld soundness.
2. Nb improves resistance to intergranular corrosion of the weld metal.
3. Weldability is excellent with lower crack susceptibility.

SG	CO ₂
Carbon	0.05 %
Silicon	0.63 %
Manganese	1.75 %
Chromium	19.5 %
Nickel	10.5 %
Niobium	0.54 %

SG	CO ₂
T-S (psi)	98,626
EI	34 %

Dia in (mm)	Electrode Extension	Amp
.045 (1.2)	.39" - .79"	100-240
1/16 (1.6)	.59" - .98"	160-260

.045" (1.2 mm) x 33# (15 kg) spool
1/16" (1.6 mm) x 33# (15 kg) spool

Detailed Packaging Information

Flat, Horizontal, Overhead, Vertical Down



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Tubular Wires

AWS EC409

K-409Ti

Typical Applications

Developed to meet the needs of the automotive exhaust fabricators that desired a metal cored wire. It excels in the pulsed GMAW mode.

Characteristics Of Usage

1. Designed for high speed welding of ferritic steels with low spatter and good bead appearance.
2. Can out perform solid wires and be more tolerant of joint variations with use of proper procedures.

Weld Metal Composition

SG	Ar+2 % O ₂
Carbon	0.05 %
Silicon	0.50 %
Manganese	0.45 %
Chromium	12.1 %
Titanium	0.7 %

Mechanical Properties

SG	Ar+2 % O ₂
T-S (psi)	81,221
EI	20 %

Available Sizes / Rec. Parameters

Dia in (mm)	Electrode Extension	Amp
.045 (1.2)	.39" - .79"	180-260
1/16 (1.6)	.59" -.98"	

Packaging

.045" (1.2 mm) x 33# (15 kg) spool
1/16" (1.6 mm) x 33# (15 kg) spool

[Detailed Packaging Information](#)

Welding Positions

Flat, Horizontal

Approved

ABS

Call Customer Service
For Availability: 1.877.754.7935

AWS EC409

K-409TiC

Developed to meet the needs of the automotive exhaust fabricators that desired a metal cored wire. It excels in the pulsed GMAW mode.

1. Designed also for high speed automotive applications where good bead appearance and tolerance to joint fit-up variations is desirable.

SG	Ar+2 % O ₂
Carbon	0.03 %
Silicon	0.55 %
Manganese	0.60 %
Chromium	11.4 %
Titanium	1.0 %

SG	Ar+2 % O ₂
T-S (psi)	79,771
EI	20 %

Dia in (mm)	Electrode Extension	Amp
.045 (1.2)	.39" - .79"	160-240
1/16 (1.6)	.59" -.98"	

.045" (1.2 mm) x 33# (15 kg) spool
1/16" (1.6 mm) x 33# (15 kg) spool

[Detailed Packaging Information](#)

Flat, Horizontal

Call Customer Service
For Availability: 1.877.754.7935

Stainless Steel

AWS E410T0-1/-4

K-410T

Designed for MAG welding of martensite stainless alloys of the 13%Cr types. It is used for surfacing of sealing faces of valves for gas, water and steam piping system at service temperatures up to 842°F.

1. Designed primarily for welding of martensitic alloys such as the 13 % chrome types
2. Preheat is recommended. Consult material manufacturer for proper procedures.

SG	CO ₂	Ar+20 % CO ₂
Carbon	0.07 %	0.07 %
Silicon	0.20 %	0.32 %
Manganese	0.47 %	0.69 %
Chromium	13.0 %	13.2 %

SG	CO ₂	Ar+20 % CO ₂
Y-S (psi)	76,870	82,672
EI	24 %	22 %
PWHT	1382°Fx1hr.	1382°Fx1hr.

Dia in (mm)	Electrode Extension	Amp
.045 (1.2)	.39" - .79"	100-240
1/16 (1.6)	.59" -.98"	180-270

.045" (1.2 mm) x 33# (15 kg) spool
1/16" (1.6 mm) x 33# (15 kg) spool

[Detailed Packaging Information](#)

Flat, Horizontal

JIS



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Tubular Wires

AWS E410NiMoT0-4

K-410NiMoT

Typical Applications

Designed for MAG welding of soft martensite stainless alloysof the 13%Cr-4%Ni-Mo types. (AISI 403, 405, 410, 420, JIS SCS3, SCS6, ASTM CAI 5M, CA6NM)

Characteristics Of Usage

1. For flat and horizontal position welding.
2. Features very good ductility, CVN toughness and crack resistance.

Weld Metal Composition

SG	Ar+20 % CO ₂
Carbon	0.04 %
Silicon	0.23 %
Manganese	0.36 %
Chromium	12.2 %
Nickel	4.1 %
Molybdenum	0.7 %

Mechanical Properties

SG	Ar+20 % CO ₂
T-S (psi)	126,183
EI	25 %
PWHT	1112°F x 1hr.

Available Sizes / Rec. Parameters

Dia in (mm)	Electrode Extension	Amp
.045 (1.2)	.39" - .79"	100-240
1/16 (1.6)	.59" - .79"	180-280

Packaging

.045" (1.2 mm) x 33# (15 kg) spool
1/16" (1.6 mm) x 33# (15 kg) spool

Detailed Packaging Information

Welding Positions

Flat, Horizontal Fillets and Groove Welds

Approved

AWS EC430

K-430T

Designed for MAG welding of ferrite stainless alloys of the 17%Cr-Ti types. Suitable for automotive exhaust fabricators such as front pipe, bellows, flange, etc. (AISI 430, dissimilar steels) (AISI 409, 430Ti, 431, ASTMA1761)

1. For high speed welding.
2. Produces a moderately soft arc and low spatter generation.
3. Provides higher corrosion resistance, heat resistance due to high alloy designs.
4. Suitable for surfacing of sealing faces of gas, water and steam valves.

SG	Ar+2 % O ₂
Carbon	0.02 %
Silicon	0.61 %
Manganese	0.49 %
Chromium	16.2 %
Nickel	1.0 %

SG	Ar+2 % O ₂
Y-P (psi)	68,893
T-S (psi)	77,595
EI	25 %
PWHT	-

Dia in (mm)	Amp F	H
.045 (1.2)	120-220	120-240
1/16 (1.6)		

.045" (1.2 mm) x 33# (15 kg) spool
1/16" (1.6 mm) x 33# (15 kg) spool

Detailed Packaging Information

Flat, Horizontal Fillets and Groove Welds

JIS

Stainless Steel

K-436T

Designed for MAG welding of stainless steels of the 17%Cr-1 Mo-Ti types. It is suitable for automotive exhaust fabricators such as front pipe, bellows, flange, etc. (AISI 430, 430Ti, 431, 436)

1. For high speed welding.
2. Produces a moderately soft arc and low spatter generation.
3. Mo component improves good crack resistance and heat resistance.
4. Suitable for surfacing of sealing faces of gas, water and steam valves.

SG	Ar+2 % O ₂
Carbon	0.03 %
Silicon	0.35 %
Manganese	0.63 %
Chromium	17.5 %
Molybdenum	1.1 %
Titanium	0.5 %

SG	Ar+2 % O ₂
Y-P (psi)	52,939
T-S (psi)	69,183
EI	23 %

Dia in (mm)	Amp F	H
.045 (1.2)	120-220	120-240
1/16 (1.6)		

.045" (1.2 mm) x 33# (15 kg) spool
1/16" (1.6 mm) x 33# (15 kg) spool

Detailed Packaging Information

Flat, Horizontal Fillets and Groove Welds

ABS, BV, DNV, GL, KR, LR, NK



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K-439T

Typical Applications

Designed for MAG welding of stainless steels of the 18%Cr-1%Ti types. It is suitable for automotive exhaust fabricators such as front pipe, bellows, flange. (AISI 430, 430Ti, 431)

Characteristics Of Usage

1. Produces moderately soft arc and low spatter levels.
2. Deposition rate can be higher than solid wires with proper welding procedures.
3. Maintains high tensile strength in high temperature atmosphere.

Weld Metal Composition

SG	Ar+2 % O₂
Carbon	0.03 %
Silicon	0.33 %
Manganese	0.64 %
Chromium	17.8 %
Nickel	0.3 %

Mechanical Properties

SG	Ar+2 % O₂
Y-P (psi)	69,908
T-S (psi)	72,664
EI	22 %

Available Sizes / Rec. Parameters

Dia in (mm)	Electrode Extension	Amp	Volt
.045 (1.2)	.39" - .79"	100-240	20-28
1/16 (1.6)	.59" - .98"	160-260	23-30

Packaging

.045" (1.2 mm) x 33# (15 kg) spool
1/16" (1.6 mm) x 33# (15 kg) spool

Detailed Packaging Information

Welding Positions

Flat, Horizontal Fillets and Groove Welds

Approved



MIG Wires

Mild Steel
High Tensile Steel
Stainless Steel



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MIG Wires AWS ER70S-3 KC-25C

AWS ER70S-3 KC-25M

Mild Steel AWS ER70S-G KC-26

Typical Applications

Used in virtually all areas of steel construction from automotive to pressure vessel shops, transportation bridges, buildings, railcar and shipbuilding.

Used in virtually all areas of steel construction from automotive to pressure vessel shops, transportation bridges, buildings, railcar and shipbuilding.

Used in virtually all areas of steel construction from automotive to pressure vessel shops, transportation bridges, buildings, railcar and shipbuilding.

Characteristics Of Usage

1. Suitable for high speed welding of steel sheet by short circuiting transfer in all positions.
2. Stable arc and low spatter loss.
3. Applicable to mixture gas(Ar+20% CO₂).

1. Wide range of operability depending on applications and procedures. Can be used in all positions with pulse equipment.
2. Stable arc and low spatter loss.

1. Wide range of operability depending on applications and procedures. Can be used in all positions with pulse equipment.
2. Stable arc and low spatter loss.
3. Suitable for high speed welding of thick plates.

Weld Metal Composition

Carbon	0.07 %
Silicon	0.67 %
Manganese	1.20 %
Phosphorus	0.015 %
Sulphur	0.011 %

Carbon	0.07 %
Silicon	0.67 %
Manganese	1.20 %
Phosphorus	0.015 %
Sulphur	0.011 %

Carbon	0.06 %
Silicon	0.80 %
Manganese	1.53 %
Phosphorus	0.014 %
Sulphur	0.010 %

Mechanical Properties

SG	CO ₂	Ar+20 % CO ₂
Y-P (psi)	62,366	63,817
T-S (psi)	75,420	78,320
EI	33 %	30 %
V-notch	66 ft/lb @ 0 °F	74 ft/lb @ 0 °F

SG	Ar+20 % CO ₂
Y-P (psi)	63,817
T-S (psi)	78,320
EI	30 %
V-notch	74 ft/lb @ 0 °F

SG	CO ₂	Ar+20 % CO ₂
Y-P (psi)	71,068	75,420
T-S (psi)	81,221	84,122
EI	29 %	30 %
V-notch	81 ft/lb @ 0 °F	89 ft/lb @ 0 °F

Available Sizes / Rec. Parameters

Dia in (mm)	Amp	
	F	V&OH
.030 (0.8)	50-120	50-100
.035 (0.9)	50-140	50-120
.040 (1.0)	80-250	60-150
.045 (1.2)	100 -350	70-200
.052 (1.4)	140-400	100-250
1/16 (1.6)	200-450	120-300

Dia in (mm)	Amp	
	F	V&OH
.030 (0.8)		
.035 (0.9)	50-200	
.040 (1.0)	70-250	
.045 (1.2)	100-350	
.052 (1.4)	140-400	
1/16 (1.6)	200-550	

Dia in (mm)	Amp	
	F	V&OH
.030 (0.8)		
.035 (0.9)	50-200	50-120
.040 (1.0)	70-250	50-150
.045 (1.2)	100-350	50-180
.052 (1.4)	140-400	100-250
1/16 (1.6)	200-550	120-300

Packaging

Detailed Packaging Information

Detailed Packaging Information

Detailed Packaging Information

Welding Positions

All position with proper equipment and procedures.

All position with proper equipment and procedures.

All position with proper equipment and procedures.

Approved

ABS, CWB, DNV, KR, LR, NK, JIS, KS

ABS, BV, DNV, GL, KR, LR, NK, JIS, KS



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MIG Wires

AWS ER70S-G

KC-27

Typical Applications

Butt and Fillet welding of vehicles, steel frames, bridges, machinery and shipbuilding.

Characteristics Of Usage

1. Stable arc, low spatter loss and less slag formation.
2. Deposited weld metal has excellent notch toughness.
3. Excellent bead appearance when used with argon CO₂ gas shielding.

Weld Metal Composition

Carbon	0.07 %
Silicon	0.62 %
Manganese	1.18 %
Phosphorus	0.014 %
Sulphur	0.010 %

Mechanical Properties

SG	Ar+20 % CO₂
Y-P (psi)	71,068
T-S (psi)	81,221
EI	31 %
V-notch	118 ft/lb @ 0 °F

Available Sizes / Rec. Parameters

Dia in (mm)	Amp	
	F	V&OH
.030 (0.8)		
.035 (0.9)		
.040 (1.0)		
.045 (1.2)	100-350	50-180
.052 (1.4)	140-400	100-250
1/16 (1.6)	200-550	120-300

Packaging

Detailed Packaging Information

Welding Positions

All position with proper equipment and procedures.

Approved

ABS, DNV, NK, JIS

AWS ER70S-6

KC-28C

Butt and Fillet welding of vehicles, building, ships, machinery and bridges in all positions.

1. Good arc characteristics in all positions due to triple deoxidizing alloy content.
2. Surface tension is conducive to all position welding especially in open root pipe or plate welding.

Carbon	0.07 %
Silicon	0.86 %
Manganese	1.53 %
Phosphorus	0.012 %
Sulphur	0.007 %

SG	CO₂	Ar+20 % CO₂
Y-P (psi)	65,267	69,618
T-S (psi)	79,771	84,122
EI	30 %	28 %
V-notch	52 ft/lb @ -20 °F	52 ft/lb @ -20 °F

Dia in (mm)	Amp	
	F	V&OH
.030 (0.8)		
.035 (0.9)	50-200	50-120
.040 (1.0)	70-250	50-150
.045 (1.2)	100-350	50-180
.052 (1.4)	140-400	100-250
1/16 (1.6)	200-550	120-300

Detailed Packaging Information

All position with proper equipment and procedures.

ABS, BV, CCS, CWB, DNV, GL, LR, KR, NK, TUV, JIS, KS

Mild Steel

AWS ER70S-2

KC-70S2

Butt and Fillet welding of vehicles, cars, ships, machinery and bridges.

1. Arc is very stable and can be used for welding steels which have a rusty or scaling surface oxide(Al, Ti, Zr).
2. Excellent for all position welding, particularly in pipe welding root passes in Mig or Tig . Weld bead wets out with good surface tension to support open root welds.

Carbon	0.07 %
Silicon	0.54 %
Manganese	1.18 %
Titanium	0.07 %
Aluminum	0.08 %
Zirconium	0.05 %

SG	CO₂	Ar+20 % CO₂
Y-P (psi)	71,068	79,771
T-S (psi)	79,771	88,473
EI	29 %	26 %
V-notch	59 ft/lb @ -20 °F	37 ft/lb @ -20 °F

Dia in (mm)	Amp	
	F	V&OH
.030 (0.8)		
.035 (0.9)	50-200	50-120
.040 (1.0)	70-250	50-150
.045 (1.2)	100-350	50-180
.052 (1.4)	140-400	100-250
1/16 (1.6)	200-550	-

Detailed Packaging Information

All position with proper equipment and procedures.



KISWEL
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MIG Wires

AWS ER70S-G

ZO-55

Typical Applications

Butt and Fillet welding of mild steel and 768 ksi class high tensile strength steel. Construction equipment, bridges and buildings.

Characteristics Of Usage

1. Excellent mechanical properties obtained under high heat input and interpass temp.
2. Excellent productivity in both fillet and groove welding in both low and high heat inputs.

Weld Metal Composition

Carbon	0.07 %
Silicon	0.92 %
Manganese	1.92 %
Titanium	0.18 %

Mechanical Properties

SG	CO ₂	CO ₂
Y-P (psi)	84,122	68,168
T-S (psi)	92,824	81,221
EI	27 %	29 %
IV	170(17) 32 °F	120(12) 32 °F
Welding	18KJ/cm,302 °F	40KJ/cm,662 °F

Available Sizes / Rec. Parameters

Dia in (mm)	Amp F	V&OH
.030 (0.8)		
.035 (0.9)		
.040 (1.0)		
.045 (1.2)	100-350	50-180
.052 (1.4)	140-400	100-250
1/16 (1.6)	200-550	120-300

Packaging

Detailed Packaging Information

Welding Positions

All position with proper equipment and procedures.

Approved

AWS ER80S-G

ZO-60

Construction machinery, bridges and storage tanks. Butt and H-fillet welding of 839 ksi class high tensile strength steel.

1. Arc is very stable, spatter is less and weldability is excellent even in high welding current range.
2. High working efficiency is obtained by automatic and semi-automatic welding due to high deposition rate and deep penetration.

Carbon	0.07 %
Silicon	0.84 %
Manganese	1.95 %
Molybdenum	0.31 %
Titanium	0.17 %

SG	CO ₂	Ar+20% CO ₂
Y-P (psi)	79,771	84,122
T-S (psi)	92,824	95,725
EI	27 %	28 %
V-notch	81 ft/lb @ 0 °F	103 ft/lb @ 0 °F

Dia in (mm)	Amp F	V&OH
.030 (0.8)		
.035 (0.9)		
.040 (1.0)		
.045 (1.2)	120-350	80-180
.052 (1.4)	150-400	100-250
1/16 (1.6)	200-500	120-300

Detailed Packaging Information

All position with proper equipment and procedures.

NK, JIS

Mild Steel



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MIG Wires
AWS ER80S-D2
KC-80D2

Call Customer Service
For Availability: 1.877.754.7935

AWS ER80S-B2
KC-80SB2

Call Customer Service
For Availability: 1.877.754.7935

High Tensile Steel
AWS ER90S-B3
KC-90SB3

Typical
Applications

Butt and Fillet welding of construction equipment, boiler, low alloy steels and 0.5%Mo alloy steel.

1.25%Cr-0.5 Mo heat resistant steels.

2.25%Cr-1% Mo heat resistant steels.

Characteristics
Of Usage

1. Used for welding steels employed at elevated temperatures up to 932 °F.
2. Where joint thickness is critical, it is important to apply the correct preheating and interpass temperatures.

1. Argon rich gas mixtures are recommended.
2. Excellent mechanical and toughness properties after PWHT.
3. Post weld heat treatment may be advisable. Follow manufacturer's recommendations.

1. Argon rich gas mixtures are recommended.
2. Excellent mechanical and toughness properties after PWHT.
3. Post weld heat treatment may be advisable. Follow manufacturer's recommendations.

Weld Metal
Composition

Carbon	0.08 %
Silicon	0.58 %
Manganese	1.85 %
Molybdenum	0.46 %

Carbon	0.09 %
Silicon	0.54 %
Manganese	0.51 %
Chromium	1.26 %
Molybdenum	0.45 %

Carbon	0.09 %
Silicon	0.47 %
Manganese	0.66 %
Chromium	2.31 %
Molybdenum	1.0 %

Mechanical
Properties

SG	Ar+2 % O₂
Y-P (psi)	88,473
T-S (psi)	100,076
EI	23 %
V-Notch	44 ft/lb @ -20 °F

SG	Ar+2 % O₂
Y-P (psi)	72,519
T-S (psi)	84,122
EI	25 %
V-Notch	59 ft/lb @ 32 °F

SG	Ar+2 % O₂
Y-P (psi)	82,672
T-S (psi)	95,725
EI	24 %
V-Notch	59 ft/lb @ 0 °F

Available Sizes /
Rec. Parameters

Dia in (mm)	Amp	
	F	V&OH
.030 (0.8)		
.035 (0.9)	50-180	50-120
.040 (1.0)	80-250	60-150
.045 (1.2)	120-350	70-200
.052 (1.4)	140 -400	100-250
1/16 (1.6)	220-450	120-250

Dia in (mm)	Amp	
	F	V&OH
.030 (0.8)		
.035 (0.9)		
.040 (1.0)		
.045 (1.2)	100-350	50-180
.052 (1.4)	140-400	100-250
1/16 (1.6)	200-550	120-300

Dia in (mm)	Amp	
	F	V&OH
.030 (0.8)		
.035 (0.9)		
.040 (1.0)		
.045 (1.2)	100-350	50-180
.052 (1.4)	140-400	100-250
1/16 (1.6)	200-550	120-300

Packaging

Detailed Packaging Information

All position with proper equipment and procedures.

Detailed Packaging Information

All position with proper equipment and procedures.

Detailed Packaging Information

All position with proper equipment and procedures.

Welding
Positions

Approved



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MIG Wires

AWS ER2209

M-2209

Typical Applications

Welding of 23%Cr-9%Ni-3%Mo stainless steels (UNS S31803, STS 329J1/329J2L). Various applications of chemical engineering, shipbuilding and nuclear plant industries, etc.

Characteristics Of Usage

1. 2209 is a duplex stainless steel for welding type 2205 duplex stainless.
2. Has a high resistance to corrosive medias such as chlorides and hydrogen sulfides
3. Good resistance to intergranular, pitting and stress corrosion cracking.

Weld Metal Composition

Carbon	0.01 %
Silicon	0.40 %
Manganese	1.75 %
Nickel	8.70 %
Chromium	22.70 %
Molybdenum	3.20 %

Mechanical Properties

SG	Ar+2 % O₂
T-S (psi)	121,832
EI	28 %
IV (J)	-51°F:110
	-321°F:50

Available Sizes / Rec. Parameters

Dia in (mm)
.030 (0.8)
.035 (0.9)
.040 (1.0)
.045 (1.2)
.052 (1.4)
1/16 (1.6)

Packaging

Detailed Packaging Information

Welding Positions

All position welding is possible with the use of proper welding equipment and procedures.

Approved

AWS ER308

M-308

Welding of 18%Cr-8%Ni stainless steels (AISI 301, 302, 304). It provides better weldability together with excellent corrosion resistance.

1. Designed for welding types 301, 302, 304, 304L, 308 and 308L grades of austenitic grades of stainless steels
2. Can also be used to weld grades 321 and 347 when service temperatures do not exceed 600°F.

Carbon	0.04 %
Silicon	0.38 %
Manganese	1.90 %
Nickel	9.80 %
Chromium	19.80 %

SG	Ar+2 % O₂
T-S (psi)	88,473
EI	40 %
IV (J)	RT:110
	-40°F:82

Dia in (mm)

.030 (0.8)
.035 (0.9)
.040 (1.0)
.045 (1.2)
.052 (1.4)
1/16 (1.6)

Detailed Packaging Information

All position welding is possible with the use of proper welding equipment and procedures.

Stainless Steel

AWS ER308H

M-308H

Welding of high carbon 18%Cr-8%Ni stainless steels (AISI 304H). It provides better weldability together with excellent corrosion resistance.

1. Product is designed primarily for welding of type 304H and and 347H austenitic stainless steels when high temperature services are required.

Carbon	0.05 %
Silicon	0.42 %
Manganese	2.06 %
Nickel	9.70 %
Chromium	19.90 %

SG	Ar+2 % O₂
T-S (psi)	85,572
EI	44 %
IV (J)	-

Dia in (mm)

.030 (0.8)
.035 (0.9)
.040 (1.0)
.045 (1.2)
.052 (1.4)
1/16 (1.6)

Detailed Packaging Information

All position welding is possible with the use of proper welding equipment and procedures.



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MIG Wires

AWS ER308L

M-308L

Typical Applications

Welding of low carbon 18%Cr-8%Ni stainless steels (AISI 304L, 308L). It provides better weldability together with excellent corrosion resistance.

Characteristics Of Usage

1. Designed for welding types 301, 302, 304, 304L, 308 and 308L grades of austenitic grades of stainless steels.
2. Can also be used to weld grades 321 and 347 when service temperatures do not exceed 600°F.

Weld Metal Composition

Carbon	0.02 %
Silicon	0.38 %
Manganese	1.90 %
Nickel	9.80 %
Chromium	19.80 %

Mechanical Properties

SG	Ar+2 % O₂
T-S (psi)	82,672
EI	44 %
IV (J)	32 °F:90
	-321 °F:82

Available Sizes / Rec. Parameters

Dia in (mm)
.030 (0.8)
.035 (0.9)
.040 (1.0)
.045 (1.2)
.052 (1.4)
1/16 (1.6)

Packaging

Detailed Packaging Information

Welding Positions

All position welding possible with proper welding equipment and procedures.

Approved

AWS ER308LSi

M-308LSi

Welding of low carbon 18%Cr-8%Ni stainless steels (AISI 304L, 308L). The high silicon content improves the welding properties, such as wetting.

1. Designed for use for most austenitic grades that normally use the 308 grade, but with added silicon that greatly enhances wetting of the weld bead. This enhances the cosmetics of the bead appearance when required .

Carbon	0.02 %
Silicon	0.75 %
Manganese	1.95 %
Nickel	10.40 %
Chromium	19.70 %

SG	Ar+2 % O₂
T-S (psi)	85,572
EI	42 %
IV (J)	32 °F:110
	-321 °F:60

Dia in (mm)
.030 (0.8)
.035 (0.9)
.040 (1.0)
.045 (1.2)
.052 (1.4)
1/16 (1.6)

Detailed Packaging Information

All position welding possible with proper welding equipment and procedures.

CWB, TUV

Stainless Steel

AWS ER309LMo

M-309LMo

Suitable for dissimilar metal joint and underlaying on ferritic steels for overlaying stainless steel weld metals.

1. Primarily for welding type 316 stainless clad steels on the root pass and some dissimilar metals with additions of Mo.
2. Also used for welding of austenitic stainless alloys to carbon steels.
3. Service temperatures should not exceed 750°F.

Carbon	0.02 %
Silicon	0.75 %
Manganese	1.45 %
Nickel	14.5 %
Chromium	23.20 %
Molybdenum	2.61 %

SG	Ar+2 % O₂
T-S (psi)	95,725
EI	33 %
IV (J)	32 °F:92
	-40 °F:89

Dia in (mm)
.030 (0.8)
.035 (0.9)
.040 (1.0)
.045 (1.2)
.052 (1.4)
1/16 (1.6)

Detailed Packaging Information

All position welding possible with proper welding equipment and procedures.



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MIG Wires

AWS ER309LSi

M-309LSi

Typical Applications

Welding of austenitic stainless alloys of the 22%Cr-12%Ni low carbon types and for joining stainless steels to non-alloy or low-alloy steels. The high silicon content improves the welding properties, such as wetting.

Characteristics Of Usage

1. Designed primarily for the joining of 309 stainless where good wetting and bead appearance are important.
2. The additional silicon aids in smooth bead contour and superior wetting into the adjacent base metal.
3. Service temperatures below 750°F.

Weld Metal Composition

Carbon	0.02 %
Silicon	0.75 %
Manganese	2.28 %
Nickel	13.70 %
Chromium	23.20 %

Mechanical Properties

SG	Ar+2 % O₂
T-S (psi)	85,572
EI	40 %
IV (J)	32 °F:90

Available Sizes / Rec. Parameters

Dia in (mm)
.030 (0.8)
.035 (0.9)
.040 (1.0)
.045 (1.2)
.052 (1.4)
1/16 (1.6)

Packaging

Detailed Packaging Information

Welding Positions

Can be used in all positions with pulsed welding equipment and good welding procedures. Non- pulsed welding is more limited to flat and horizontal welding.

Approved

Call Customer Service
For Availability: 1.877.754.7935

AWS ER310

M-310

Welding of heat-resistant austenitic steels of the 25%Cr-20%Ni types(STS310S). It has good general oxidation resistance, especially at high temperature.

1. Developed primarily for welding type 310 stainless.
2. Can also be used to join types 410 and 430 stainless when preheating and heat treatment are not practical.

Carbon	0.10 %
Silicon	0.10 %
Manganese	1.73 %
Nickel	20.90 %
Chromium	26.60 %

SG	Ar+2 % O₂
T-S (psi)	87,023
EI	40 %
IV (J)	32 °F:110

Dia in (mm)
.030 (0.8)
.035 (0.9)
.040 (1.0)
.045 (1.2)
.052 (1.4)
1/16 (1.6)

Detailed Packaging Information

Can be used in all positions with pulsed welding equipment and good welding procedures. Non- pulsed welding is more limited to flat and horizontal welding.

Call Customer Service
For Availability: 1.877.754.7935

Stainless Steel

AWS ER312

M-312

Welding of stainless steel of the 29%Cr-9%Ni types. Wire is widely used for joining of dissimilar metals such as carbon steel to stainless steel.

1. Type 312 was originally designed to join high temperature heat resistant alloys as well as strength high alloy steels to themselves and some dissimilar metals
2. 312 can also be used to join some abrasion resistant steels.

Carbon	0.10 %
Silicon	0.43 %
Manganese	1.72 %
Nickel	8.70 %
Chromium	30.40 %

SG	Ar+2 % O₂
T-S (psi)	105,878
EI	30 %
IV (J)	-

Dia in (mm)
.030 (0.8)
.035 (0.9)
.040 (1.0)
.045 (1.2)
.052 (1.4)
1/16 (1.6)

Detailed Packaging Information

Can be used in all positions with pulsed welding equipment and good welding procedures. Non- pulsed welding is more limited to flat and horizontal welding.



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MIG Wires

AWS ER316

M-316

Typical Applications

Welding of stainless steel of 18%Cr-12%Ni-Mo types (STS316). The low ferrite content improves the crack-resistance and corrosion resistance.

Characteristics Of Usage

Designed for use on type 316 austenitic stainless steels.

Weld Metal Composition

Carbon	0.04 %
Silicon	0.40 %
Manganese	1.62 %
Nickel	12.10 %
Chromium	18.40 %
Molybdenum	2.30 %

Mechanical Properties

SG	Ar+2 % O₂
T-S (psi)	84,122
EI	38 %
IV (J)	32°F:100 385 °F:50

Available Sizes / Rec. Parameters

Dia in (mm)
.030 (0.8)
.035 (0.9)
.040 (1.0)
.045 (1.2)
.052 (1.4)
1/16 (1.6)

Packaging

Detailed Packaging Information

Welding Positions

Can be used in all positions with pulsed welding equipment and good welding procedures. Non-pulsed welding is more limited to flat and horizontal welding.

Approved

AWS ER316L

M-316L

Welding of austenitic stainless alloys of the 18%Cr-12%Ni-Mo low carbon types. The alloy has particularly good corrosion-resistance and heat-resistance.

Designed for use on type 316 L and 316 grade austenitic stainless steels.

Carbon	0.02 %
Silicon	0.39 %
Manganese	1.89 %
Nickel	11.80 %
Chromium	18.60 %
Molybdenum	2.20 %

SG	Ar+2 % O₂
T-S (psi)	84,122
EI	38 %
IV (J)	32°F:90 385 °F:62

Dia in (mm)
.030 (0.8)
.035 (0.9)
.040 (1.0)
.045 (1.2)
.052 (1.4)
1/16 (1.6)

Detailed Packaging Information

Can be used in all positions with pulsed welding equipment and good welding procedures. Non-pulsed welding is more limited to flat and horizontal welding.

BV, DNV, KR

Stainless Steel

AWS ER316LSi

M-316LSi

Welding of austenitic stainless alloys of the 18%Cr-12%Ni-Mo low carbon types. The high silicon content improves the welding properties, such as wetting.

1. Designed for use for type 316L grade stainless steel.
- 2 The additional silicon greatly enhances wetting of the weld bead that enhances the cosmetics of the bead appearance when required.

Carbon	0.02 %
Silicon	0.76 %
Manganese	1.85 %
Chromium	12.20 %
Nickel	18.70 %
Molybdenum	2.30 %

SG	Ar+2 % O₂
T-S (psi)	82,672
EI	30 %
IV (J)	32°F:110 -321 °F:40

Dia in (mm)
.030 (0.8)
.035 (0.9)
.040 (1.0)
.045 (1.2)
.052 (1.4)
1/16 (1.6)

Detailed Packaging Information

Can be used in all positions with pulsed welding equipment and good welding procedures. Non-pulsed welding is more limited to flat and horizontal welding.

ABS, TUV



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MIG Wires

AWS ER317L

M-317L

Typical Applications

Welding of stainless alloys of the 19%Cr-12%Ni-3.5%Mo low carbon types (STS317, 317L). Various applications of chemical engineering, shipbuilding and nuclear plant industries, etc.

Characteristics Of Usage

1. Recommended for welding type 317 and 317L stainless steels with up to .04 % carbon in the weld deposit.
2. The higher Molybdenum content increases the resistance to pitting corrosion.

Weld Metal Composition

Carbon	0.02 %
Silicon	0.48 %
Manganese	1.09 %
Nickel	13.10 %
Chromium	18.90 %
Molybdenum	3.40 %

Mechanical Properties

SG	Ar+2 % O₂
T-S (psi)	92,824
EI	40 %
IV (J)	-

Available Sizes / Rec. Parameters

Dia in (mm)
.030 (0.8)
.035 (0.9)
.040 (1.0)
.045 (1.2)
.052 (1.4)
1/16 (1.6)

Packaging

Detailed Packaging Information

Welding Positions

Can be used in all positions with the use of pulsed welding equipment and proper welding procedures.

Approved

AWS ER347

M-347

Welding of stainless alloys of the 18%Cr-9%Ni-Nb(Ti) types (STS 321, 347). Nb component improves the resistance to intergranular corrosion of the weld metal.

1. Designed for welding of grades 347 and 321 stabilized austenitic stainless steels.
2. Operating temperatures should not exceed 750 °F.

Carbon	0.05 %
Silicon	0.46 %
Manganese	2.24 %
Nickel	9.30 %
Chromium	19.30 %
Niobium/Tantalum	0.60 %

SG	Ar+2 % O₂
T-S (psi)	92,824
EI	41 %
IV (J)	-

Dia in (mm)

.030 (0.8)
.035 (0.9)
.040 (1.0)
.045 (1.2)
.052 (1.4)
1/16 (1.6)

Detailed Packaging Information

Can be used in all positions with the use of pulsed welding equipment and proper welding procedures.

Stainless Steel

AWS ER409Nb

M-409Nb

Welding of ferrite stainless alloys of the 13%Cr types (AISI409). It is suitable for automotive exhaust fabricators such as front pipe, bellows, flange.

1. This product was designed for welding Niobium stabilized stainless.
2. The added Nb helps to form stable carbides that promote improved resistance to corrosion with stronger properties at elevated temperatures.

Carbon	0.01 %
Silicon	0.45 %
Manganese	0.46 %
Nickel	0.23 %
Chromium	11.40 %
Niobium/Tantalum	0.36 %

SG	Ar+2 % O₂
T-S (psi)	4,438 (1562°F)
EI	56 %
IV (J)	-

Dia in (mm)

.030 (0.8)
.035 (0.9)
.040 (1.0)
.045 (1.2)
.052 (1.4)
1/16 (1.6)

Detailed Packaging Information

Can be used in all positions with the use of pulsed welding equipment and proper welding procedures.



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MIG Wires

AWS ER410

M-410

Typical Applications

Welding of martensite stainless alloys of the 13%Cr types (STS 403, 410). The alloy is suitable for the first layer of corrosion resistant weld claddings.

Characteristics Of Usage

1. Alloy 410 is used to weld Types 403, 405, 410 and 416.
2. Alloy 410 is also used for welding overlay on carbon steels to resist corrosion, erosion, or abrasion.

Weld Metal Composition

Carbon	0.02 %
Silicon	0.34 %
Manganese	0.39 %
Nickel	-
Chromium	12.80 %

Mechanical Properties

SG	Ar+2 % O₂
T-S (psi)	78,320
EI	35 %
Remark	PWHT:1373 °F x 1hr

Available Sizes / Rec. Parameters

Dia in (mm)
.030 (0.8)
.035 (0.9)
.040 (1.0)
.045 (1.2)
.052 (1.4)
1/16 (1.6)

Packaging

[Detailed Packaging Information](#)

Welding Positions

Approved

AWS ER420

M-420

Welding of martensite stainless alloys of the 13%Cr types (STS 420). The alloy is suitable for the first layer of corrosion resistant weld claddings.

1. Type 420 is a martensitic stainless steel that provides corrosion resistance similar to Type 410 plus increased strength and hardness
2. Typical uses include cutlery, surgical and dental instruments, scissors, tapes and straight edges.

Carbon	0.33 %
Silicon	0.41 %
Manganese	0.37 %
Nickel	-
Chromium	12.70 %

SG	Ar+2 % O₂
T-S (psi)	-
EI	-
5%H₂SO₄	-

Dia in (mm)
.030 (0.8)
.035 (0.9)
.040 (1.0)
.045 (1.2)
.052 (1.4)
1/16 (1.6)

[Detailed Packaging Information](#)

Stainless Steel

AWS ER430

M-430

Welding of ferrite stainless alloys of the 17%Cr types (AISI 430, dissimilar steels). It is suitable for automotive exhaust fabricators such as front pipe, bellows, flange.

1. Alloy 430 is a ferritic stainless which provides good ductility in heat-treated condition.
2. Used in the application of welding similar alloys as well as for overlays and thermal spraying.
3. A minimum of 300°F before welding.

Carbon	0.02 %
Silicon	0.33 %
Manganese	0.44 %
Nickel	-
Chromium	16.60 %

SG	Ar+2 % O₂
T-S (psi)	73,969
EI	35 %
Remark	PWHT:1373 °F x 1hr

Dia in (mm)
.030 (0.8)
.035 (0.9)
.040 (1.0)
.045 (1.2)
.052 (1.4)
1/16 (1.6)

[Detailed Packaging Information](#)



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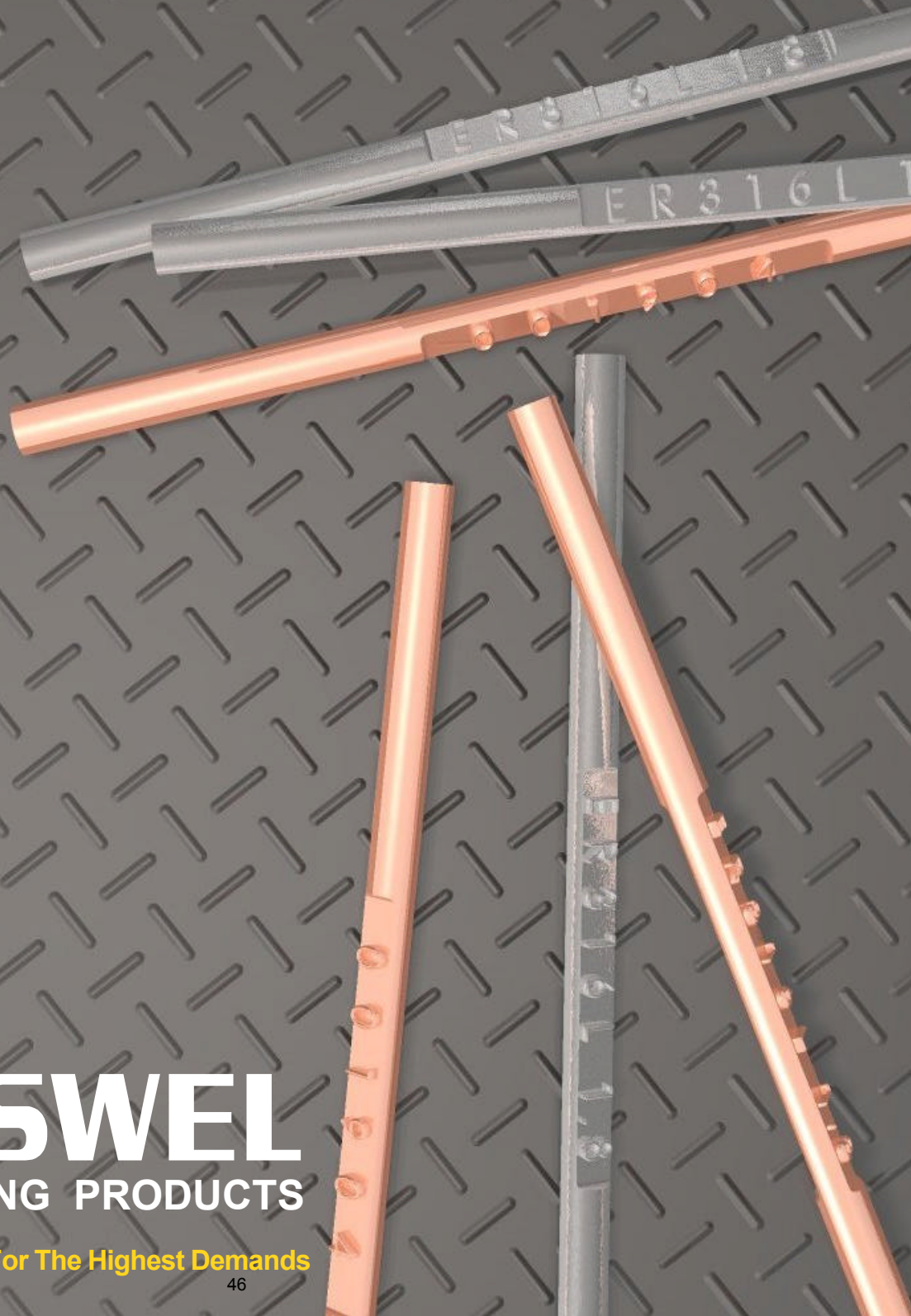
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TIG Wires

Mild Steel

Stainless Steel



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TIG Wires AWS ER70S-2 T-70S2

AWS ER80S-D2 T-80D2

Mild Steel AWS ER80S-B2 T-80SB2

Typical Applications

Excellent wire for Tig or Mig welding of most grades of carbon steels, pipe, offshore drilling rigs and structural steels.

For use on carbon and low alloy steels such as 4130 when matching tensile strength or PWHT is required.

For welding of 1.25% Cr / 0.5 Mo heat resisting steels.

Characteristics Of Usage

1. Multiple deoxidized rod containing small amounts of zirconium, titanium and aluminum in addition to the manganese and silicon deoxidizers.
2. Produces superior quality welds with minimum porosity even over rust and mill scale.

1. Gives high strength welds on high sulphur bearing steels or medium carbon steels.
2. Contains additional amounts of manganese and silicon which produces weld deposits with high ductility, excellent impact values and tensile strength.

1. Ar gas is used for shielding.
2. Excellent mechanical and toughness properties after PWHT.
3. Preheat at 212° to 392 °F and post weld heat treatment at 1148 °F to 1328 °F.

Weld Metal Composition

Carbon	0.07 %
Silicon	0.54 %
Manganese	1.18 %
Titanium	0.07 %
Aluminum	0.08 %
Zirconium	0.04 %

Carbon	0.08 %
Silicon	0.63 %
Manganese	1.85 %
Molybdenum	0.50 %

Carbon	0.09 %
Silicon	0.54 %
Manganese	0.51 %
Chromium	1.26 %
Molybdenum	0.45 %

Mechanical Properties

Y-P	71,068
T-S (psi)	82,672
EI	29 %
V-Notch	133 ft/lb @ -20 °F

Y-P	88,473
T-S (psi)	101,526
EI	22 %
V-Notch	133 ft/lb @ -20 °F

Y-P	72,519
T-S (psi)	85,572
EI	26 %
V-Notch	59 ft/lb @ 32 °F

Available Sizes / Rec. Parameters

Dia in (mm)	Length in (mm)	Amp	
		F	V&OH
1/16" (1.6)	39(1000)	30-150	30-130
3/32" (2.4)	39(1000)	40-200	40-180
1/8" (3.0)	39(1000)	50-250	50-210
5/32" (4.0)	39(1000)	70-325	70-280

Dia in (mm)	Length in (mm)	Amp	
		F	V&OH
1/16" (1.6)	39(1000)	30-150	30-130
3/32" (2.4)	39(1000)	40-200	40-180
1/8" (3.0)	39(1000)	50-250	50-210
5/32" (4.0)	39(1000)	70-325	70-280

Dia in (mm)	Length in (mm)	Amp	
		F	V&OH
1/16" (1.6)	39(1000)	30-150	30-130
3/32" (2.4)	39(1000)	40-200	40-180
1/8" (3.0)	39(1000)	50-250	50-210
5/32" (4.0)	39(1000)	70-325	70-280

Packaging

10# (5 kg) carton

10# (5 kg) carton

10# (5 kg) carton

[Detailed Packaging Information](#)

[Detailed Packaging Information](#)

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Welding Positions

All Welding Positions

All Welding Positions

All Welding Positions

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TIG Wires
AWS ER90S-B3
T90SB3

Mild Steel

Typical
Applications

Designed for welding 2.25% Cr, 1% Mo alloy steels

Characteristics
Of Usage

1. Designed for single and multi-pass welding of 2.25% Cr, 1% Mo alloy steels.
2. Excellent mechanical and toughness properties after PWHT.
3. Preheat at 300° to 570°F and post weld heat treatment at 1256° to 1346°F .

Weld Metal
Composition

Carbon	0.09 %
Silicon	0.47 %
Manganese	0.66 %
Chromium	2.31 %
Molybdenum	1.0 %

Mechanical
Properties

Y-P (psi)	79,771
T-S (psi)	97,175
EI	26 %
V-Notch	133 ft/lb @ 32°F

Available Sizes /
Rec. Parameters

Dia in (mm)	Length in (mm)	Amp F	V&OH
1/16" (1.6)	39(1000)	30-150	30-130
3/32" (2.4)	39(1000)	40-200	40-180
1/8" (3.0)	39(1000)	50-250	50-210
5/32"(4.0)	39(1000)	70-325	70-280

Packaging

10# (5 kg) carton

[Detailed Packaging Information](#)

Welding
Positions

All Welding Positions

Approved



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WELDING PRODUCTS

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TIG Wires AWS ER2209 T-2209

Typical Applications

Welding of 23%Cr-9%Ni-3%Mo stainless steels (UNS S31803, STS 329J1/329J2L). Various applications of chemical engineering, shipbuilding and nuclear plant industries etc.

Characteristics Of Usage

Duplex stainless steels are typically used in:

1. Chemical processing, transport and storage
2. Oil and gas refining
3. Pulp & paper manufacturing

Weld Metal Composition

Carbon	0.01 %
Silicon	0.40 %
Manganese	1.75 %
Nickel	8.70 %
Chromium	22.70 %
Molybdenum	3.20 %

Mechanical Properties

SG	Ar
T-S (psi)	118,206
EI	35 %
IV (J)	-51°F:136

Available Sizes / Rec. Parameters

Dia in (mm)	Length in (mm)	Weight lb(kg)
.045 (1.2)	39 (1000)	11 (5)
1/16 (1.6)	39 (1000)	11 (5)
5/64 (2.0)	39 (1000)	11 (5)
3/32 (2.4)	39 (1000)	11 (5)
1/8 (3.2)	39 (1000)	11 (5)
5/32 (4.0)	39 (1000)	11 (5)

Packaging

10# (5 kg) carton

[Detailed Packaging Information](#)

Welding Positions

All Welding Positions

Approved

ABS

AWS ER308 T-308

Welding of 18%Cr-8%Ni stainless steels (AISI 301, 302, 304). It provides better weldability together with excellent corrosion resistance.

304 stainless steel are typically used in fabrication of:

1. Sinks and kitchen appliances
2. Cutlery and flatware
3. Brewery, dairy product equipment, food and pharmaceutical production equipment

Carbon	0.04 %
Silicon	0.38 %
Manganese	1.90 %
Nickel	9.80 %
Chromium	19.80 %

SG	Ar
T-S (psi)	84,122
EI	42 %
IV (J)	32 °F:150 -321 °F:40

Dia in (mm)	Length in (mm)	Weight lb(kg)
.045 (1.2)	39 (1000)	11 (5)
1/16 (1.6)	39 (1000)	11 (5)
5/64 (2.0)	39 (1000)	11 (5)
3/32 (2.6)	39 (1000)	11 (5)
1/8 (3.2)	39 (1000)	11 (5)
5/32 (4.0)	39 (1000)	11 (5)

10# (5 kg) carton

[Detailed Packaging Information](#)

All Welding Positions

Call Customer Service
For Availability: 1.877.754.7935

Stainless Steel AWS ER308H T-308H

Welding of high carbon 18%Cr-8%Ni stainless steels (AISI 304H). It provides better weldability together with excellent corrosion resistance.

1. Product is designed primarily for welding of type 304H and and 347H austenitic stainless steels when high temperature services are required.

Carbon	0.05 %
Silicon	0.42 %
Manganese	2.06 %
Nickel	9.80 %
Chromium	19.80 %

SG	Ar
T-S (psi)	85,572
EI	42 %
IV (J)	-

Dia in (mm)	Length in (mm)	Weight lb(kg)
.045 (1.2)	39 (1000)	11 (5)
1/16 (1.6)	39 (1000)	11 (5)
3/32 (2.0)	39 (1000)	11 (5)
1/8 (3.2)	39 (1000)	11 (5)
5/32 (4.0)	39 (1000)	11 (5)

10# (5 kg) carton

[Detailed Packaging Information](#)

All Welding Positions



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TIG Wires AWS ER308L T-308L

Typical Applications

Welding of low carbon 18%Cr-8%Ni stainless steels (AISI 301, 302, 304L, 308L). It provides better weldability together with excellent corrosion resistance.

Characteristics Of Usage

304 stainless steel are typically used in fabrication of:

1. Sinks and kitchen appliances
2. Cutlery and flatware
3. Brewery, dairy product equipment, food and pharmaceutical production equipment

Weld Metal Composition

Carbon	0.02 %
Silicon	0.38 %
Manganese	1.90 %
Nickel	9.80 %
Chromium	19.80 %

Mechanical Properties

SG	Ar
T-S (psi)	84,122
EI	44 %
IV (J)	32 °F:160 -321 °F:80

Available Sizes / Rec. Parameters

Dia in (mm)	Length in (mm)	Weight lb(kg)
.045 (1.2)	39 (1000)	11 (5)
1/16 (1.6)	39 (1000)	11 (5)
5/64 (2.0)	39 (1000)	11 (5)
3/32 (2.6)	39 (1000)	11 (5)
1/8 (3.2)	39 (1000)	11 (5)
5/32 (4.0)	39 (1000)	11 (5)

Packaging

10# (5 kg) carton

Detailed Packaging Information

Welding Positions

All Welding Positions

Approved

BV, LR, DNV, KR, TUV

Call Customer Service
For Availability: 1.877.754.7935

AWS ER308LSi T-308LSi

Welding of low carbon 18%Cr-8%Ni stainless steels (AISI 304L, 308L). The high silicon content improves the welding properties, such as wetting.

1. Designed for use with most austenitic grades that normally use the 308 grade, but with added silicon that greatly enhances wetting of the weld bead. This enhances the cosmetics of the bead appearance when required .

Carbon	0.02 %
Silicon	0.75 %
Manganese	1.95 %
Nickel	10.4 %
Chromium	19.7 %

SG	Ar
T-S (psi)	84,122
EI	43 %
IV (J)	32 °F:180 -321 °F:80

Dia in (mm)	Length in (mm)	Weight lb(kg)
.045 (1.2)	39 (1000)	11 (5)
1/16 (1.6)	39 (1000)	11 (5)
3/32 (2.0)	39 (1000)	11 (5)
1/8 (3.2)	39 (1000)	11 (5)
5/32 (4.0)	39 (1000)	11 (5)

10# (5 kg) carton

Detailed Packaging Information

All Welding Positions

CWB

Call Customer Service
For Availability: 1.877.754.7935

Stainless Steel AWS ER309 T-309

Welding of similar alloys in wrought or cast forms. Welding of dissimilar steels, such as 304L to mild steel or low alloy steels.

1. Used for welding of carbon steel to stainless steels.
2. Also used for overlay cladding of carbon and alloy steels.
3. Intended for service temperatures below 600° F.

Carbon	0.05 %
Silicon	0.36 %
Manganese	1.84 %
Nickel	13.3 %
Chromium	23.60 %

SG	Ar
T-S (psi)	88,473
EI	40 %
IV (J)	32 °F:150

Dia in (mm)	Length in (mm)	Weight lb(kg)
.045 (1.2)	39 (1000)	
1/16 (1.6)	39 (1000)	
3/32 (2.0)	39 (1000)	
1/8 (3.2)	39 (1000)	
5/32 (4.0)	39 (1000)	

10# (5 kg) carton

Detailed Packaging Information

All Welding Positions



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WELDING PRODUCTS

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TIG Wires

AWS ER309L

T-309L

Typical Applications

Welding of similar alloys in wrought or cast forms and clad side of type 304L clad steels. The low ferrite content improves the crack-resistance and corrosion-resistance.

Characteristics Of Usage

1. Used for welding of carbon steel to stainless steels.
2. Also used for overlay cladding of carbon and alloy steels.
3. Intended for service temperatures below 600°F.

Weld Metal Composition

Carbon	0.01 %
Silicon	0.40 %
Manganese	1.92 %
Nickel	13.80 %
Chromium	23.20 %

Mechanical Properties

SG	Ar
T-S (psi)	85,572
EI	42 %
IV (J)	32 °F:110

Available Sizes / Rec. Parameters

Dia in (mm)	Length in (mm)	Weight lb(kg)
.045 (1.2)	39 (1000)	11 (5)
1/16 (1.6)	39 (1000)	11 (5)
3/32 (2.0)	39 (1000)	11 (5)
1/8 (3.2)	39 (1000)	11 (5)
5/32 (4.0)	39 (1000)	11 (5)

Packaging

10# (5 kg) carton

Detailed Packaging Information

Welding Positions

All Welding Positions

Approved

BV, LR, DNV, KR

AWS ER309LSi

T-309LSi

Welding of austenitic stainless alloys of the 22%Cr-12%Ni low carbon types and for joining stainless steels to non-alloy or low-alloy steels. The high silicon content improves the welding properties, such as wetting.

1. Silicon enhanced version of the 309L product that significantly improves the wetting out of the weld bead and base metal transitions.
2. Used on dissimilar welding, carbon to stainless and corrosion cladding applications.

Carbon	0.02 %
Silicon	0.75 %
Manganese	2.28 %
Nickel	13.70 %
Chromium	23.20 %

SG	Ar
T-S (psi)	79,771
EI	42 %
IV (J)	32 °F:120

Dia in (mm)	Length in (mm)	Weight lb(kg)
.045 (1.2)	39 (1000)	11 (5)
1/16 (1.6)	39 (1000)	11 (5)
3/32 (2.0)	39 (1000)	11 (5)
1/8 (3.2)	39 (1000)	11 (5)
5/32 (4.0)	39 (1000)	11 (5)

10# (5 kg) carton

Detailed Packaging Information

All Welding Positions

Stainless Steel

AWS ER310

T-310

Welding of heat-resistant austenitic steels of the 25%Cr-20%Ni types(STS310S). It has good general oxidation resistance, especially at high temperature.

1. Designed for welding of 310 stainless steels for high temperature applications.
2. Typical uses include oven linings, furnace components, annealing covers and fire box sheets.

Carbon	0.10 %
Silicon	0.43 %
Manganese	1.73 %
Nickel	20.90 %
Chromium	26.60 %

SG	Ar
T-S (psi)	87,023
EI	40 %
IV (J)	32 °F:110

Dia in (mm)	Length in (mm)	Weight lb(kg)
.045 (1.2)	39 (1000)	11 (5)
1/16 (1.6)	39 (1000)	11 (5)
3/32 (2.0)	39 (1000)	11 (5)
1/8 (3.2)	39 (1000)	11 (5)
5/32 (4.0)	39 (1000)	11 (5)

10# (5 kg) carton

Detailed Packaging Information

All Welding Positions



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TIG Wires

AWS ER312

T-312

Typical Applications

Welding of stainless steel of the 29%Cr-9%Ni types. Wire is widely used for joining of dissimilar metals such as carbon steel to stainless steel.

Characteristics Of Usage

1. Type 312 was originally designed to join high temperature heat resistant alloys as well as strength high alloy steels to themselves and some dissimilar metals
2. 312 can also be used to join some abrasion resistant steels.

Weld Metal Composition

Carbon	0.10 %
Silicon	0.43 %
Manganese	1.73 %
Nickel	8.7 %
Chromium	30.4 %

Mechanical Properties

SG	Ar
T-S (psi)	114,580
EI	25 %
IV (J)	-

Available Sizes / Rec. Parameters

Dia in (mm)	Length in (mm)	Weight lb(kg)
.045 (1.2)	39 (1000)	11 (5)
1/16 (1.6)	39 (1000)	11 (5)
3/32 (2.0)	39 (1000)	11 (5)
1/8 (3.2)	39 (1000)	11 (5)
5/32 (4.0)	39 (1000)	11 (5)

Packaging

10# (5 kg) carton

[Detailed Packaging Information](#)

Welding Positions

All Welding Positions

Approved



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AWS ER316

T-316

Welding of stainless steel of 18%Cr-12%Ni-Mo types (STS316). The low ferrite content improves the crack-resistance and corrosion resistance.

Designed for use on type 316 austenitic stainless steels.

Carbon	0.04 %
Silicon	0.40 %
Manganese	1.62 %
Nickel	12.10 %
Chromium	18.40 %
Molybdenum	2.30 %

SG	Ar
T-S (psi)	82,672
EI	40 %
IV (J)	32 °F:140 -321 °F:50

Dia in (mm)	Length in (mm)	Weight lb(kg)
.045 (1.2)	39 (1000)	11 (5)
1/16 (1.6)	39 (1000)	11 (5)
3/32 (2.0)	39 (1000)	11 (5)
1/8 (3.2)	39 (1000)	11 (5)
5/32 (4.0)	39 (1000)	11 (5)

10# (5 kg) carton

[Detailed Packaging Information](#)

All Welding Positions

Stainless Steel

AWS ER316L

T-316L

Welding of austenitic stainless alloys of the 18%Cr-12%Ni-Mo low carbon types. The alloy has particularly good corrosion-resistance and heat-resistance.

Designed for use on type 316 L and 316 grade austenitic stainless steels.

Carbon	0.02 %
Silicon	0.39 %
Manganese	1.85 %
Nickel	12.20 %
Chromium	18.70 %
Molybdenum	2.30 %

SG	Ar
T-S (psi)	81,221
EI	40 %
IV (J)	32 °F:150 -321 °F:50

Dia in (mm)	Length in (mm)	Weight lb(kg)
.045 (1.2)	39 (1000)	)
1/16 (1.6)	39 (1000)	
3/32 (2.0)	39 (1000)	
1/8 (3.2)	39 (1000)	
5/32 (4.0)	39 (1000)	

10# (5 kg) carton

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All Welding Positions

ABS, BV, LR, DNV, KR, TUV

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TIG Wires

AWS ER316LSi

T-316LSi

Typical Applications

Welding of austenitic stainless alloys of the 18%Cr-12%Ni-Mo low carbon types. The high silicon content improves the welding properties, such as wetting.

Characteristics Of Usage

1. Designed for use for type 316L grade stainless steel.
2. The additional silicon greatly enhances wetting of the weld bead that enhances the cosmetics of the bead appearance when required .

Weld Metal Composition

Carbon	0.02 %
Silicon	0.76 %
Manganese	1.85 %
Nickel	12.20 %
Chromium	18.70 %
Molybdenum	2.30 %

Mechanical Properties

SG	Ar
T-S (psi)	81,221
EI	40 %
IV (J)	32 °F:150
	-321 °F:50

Available Sizes / Rec. Parameters

Dia in (mm)	Length in (mm)	Weight lb(kg)
.045 (1.2)	39 (1000)	11 (5)
1/16 (1.6)	39 (1000)	11 (5)
3/32 (2.0)	39 (1000)	11 (5)
1/8 (3.2)	39 (1000)	11 (5)
5/32 (4.0)	39 (1000)	11 (5)

Packaging

10# (5 kg) carton

Detailed Packaging Information

Welding Positions

All Welding Positions

Approved

AWS ER317L

T-317L

Welding of stainless alloys of the 19%Cr-12%Ni-3.5%Mo low carbon types (STS317, 317L). Various applications of chemical engineering, shipbuilding and nuclear plant industries etc.

1. Recommended for welding type 317 and 317L stainless steels with up to .04% carbon in the weld deposit.
2. The higher Molybdenum content increases the resistance to pitting corrosion.

Carbon	0.02 %
Silicon	0.49 %
Manganese	1.85 %
Nickel	14.10 %
Chromium	18.70 %
Molybdenum	3.40 %

SG	Ar
T-S (psi)	81,221
EI	40 %
IV (J)	32 °F:150
	-321 °F:50

Dia in (mm)	Length in (mm)	Weight lb(kg)
.045 (1.2)	39 (1000)	11 (5)
1/16 (1.6)	39 (1000)	11 (5)
3/32 (2.0)	39 (1000)	11 (5)
1/8 (3.2)	39 (1000)	11 (5)
5/32 (4.0)	39 (1000)	11 (5)

10# (5 kg) carton

Detailed Packaging Information

All Welding Positions

Stainless Steel

AWS ER347

T-347

Welding of stainless alloys of the 18%Cr-9%Ni-Nb(Ti) types (STS 321, 347). Nb component improves the resistance to intergranular corrosion of the weld metal.

1. This product was designed for welding 347 Niobium stabilized stainless.
2. The added Nb helps to form stable carbides that promote improved resistance to corrosion with stronger properties at elevated temperatures.

Carbon	0.05 %
Silicon	0.46 %
Manganese	2.24 %
Nickel	9.30 %
Chromium	19.30 %
Niobium/Tantalum	0.60 %

SG	Ar
T-S (psi)	91,374
EI	40 %
IV (J)	32 °F:90
	-321 °F:36

Dia in (mm)	Length in (mm)	Weight lb(kg)
.045 (1.2)	39 (1000)	
1/16 (1.6)	39 (1000)	
3/32 (2.0)	39 (1000)	
1/8 (3.2)	39 (1000)	
5/32 (4.0)	39 (1000)	

10# (5 kg) carton

Detailed Packaging Information

All Welding Positions



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TIG Wires

AWS ER410

T-410

Typical Applications

Welding of martensite stainless alloys of the 13%Cr types (STS 403, 410). The alloy is suitable for the first layer of corrosion resistant weld claddings.

Characteristics Of Usage

1. Alloy 410 is used to weld Types 403, 405, 410 and 416.
2. Alloy 410 is also used for welding overlay on carbon steels to resist corrosion, erosion, or abrasion.

Weld Metal Composition

Carbon	0.02 %
Silicon	0.34 %
Manganese	0.39 %
Nickel	-
Chromium	12.80 %

Mechanical Properties

SG	Ar
T-S (psi)	76,870
EI	37 %
Remark	PWHT:1373 °F x 1hr

Available Sizes / Rec. Parameters

Dia in (mm)	Length in (mm)	Weight lb(kg)
.045 (1.2)	39 (1000)	11 (5)
1/16 (1.6)	39 (1000)	11 (5)
3/32 (2.0)	39 (1000)	11 (5)
1/8 (3.2)	39 (1000)	11 (5)
5/32 (4.0)	39 (1000)	11 (5)

Packaging

10# (5 kg) carton

Detailed Packaging Information

Welding Positions

All Welding Positions

Approved

AWS ER420

T-420

Welding of martensite stainless alloys of the 13%Cr types (STS 420). The alloy is suitable for the first layer of corrosion resistant weld claddings.

1. Type 420 is a martensitic stainless steel that provides corrosion resistance similar to Type 410 plus increased strength and hardness
2. Typical uses include cutlery, surgical and dental instruments, scissors, tapes and straight edges.

Carbon	0.33 %
Silicon	0.41 %
Manganese	0.37 %
Nickel	-
Chromium	12.70 %

SG	Ar
T-S (psi)	-
EI	-
IV(J)	-

Dia in (mm)	Length in (mm)	Weight lb(kg)
.045 (1.2)	39 (1000)	11 (5)
1/16 (1.6)	39 (1000)	11 (5)
3/32 (2.0)	39 (1000)	11 (5)
1/8 (3.2)	39 (1000)	11 (5)
5/32 (4.0)	39 (1000)	11 (5)

10# (5 kg) carton

Detailed Packaging Information

All Welding Positions

Stainless Steel

AWS ER430

T-430

Welding of ferrite stainless alloys of the 17%Cr types (ASI 430, dissimilar steels). It is suitable for automotive exhaust fabricators such as front pipe, bellows, flange.

1. Ferritic stainless which provides good ductility in heat-treated condition.
2. It is also used in the application of welding similar alloys as well as for overlays and thermal spraying.
3. A minimum of 300°F is recommended before welding.

Carbon	0.02 %
Silicon	0.33 %
Manganese	0.44 %
Nickel	-
Chromium	16.60 %

SG	Ar
T-S (psi)	72,519
EI	33 %
Remark	PWHT:1373 °F x 1hr

Dia in (mm)	Length in (mm)	Weight lb(kg)
.045 (1.2)	39 (1000)	11 (5)
1/16 (1.6)	39 (1000)	11 (5)
3/32 (2.0)	39 (1000)	11 (5)
1/8 (3.2)	39 (1000)	11 (5)
5/32 (4.0)	39 (1000)	11 (5)

10# (5 kg) carton

Detailed Packaging Information

All Welding Positions



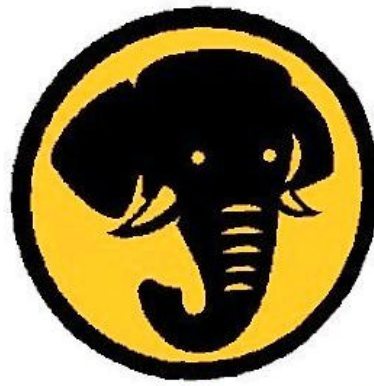
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KISWEL



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Covered Electrodes

Specific Product Packaging Information

3/32" (2.6mm)	10# (5 kg) cartons
1/8" (3.2mm)	10# (5 kg) cartons
5/32" (4.0mm)	10# (5 kg) cartons
3/16" (5.0mm)	10# (5 kg) cartons
7/32" (5.6mm)	10# (5 kg) cartons
1/4" (6.0mm)	10# (5 kg) cartons

Detailed Packaging Information

Pounds	Metric	Type	Per Carton	Per Pallet	Total Weight
10 lb	5 kg	Carton	6	60	3,000 lbs (1361 kg)



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Specific Product Packaging Information

.045" (1.2mm)	33# (15 kg) spool 60# (27.2 kg) coil 500# (227 kg) drum pack
1/16" (1.6mm)	33# (15 kg) spool 60# (27.2 kg) coil 500# (227 kg) drum pack
5/64" (2.0mm)	60# (27.2 kg) coil 500# (227 kg) drum pack
3/32" (2.4mm) x	60# (27.2 kg) coil 500# (227 kg) drum pack

Detailed Packaging Information

Pounds	Metric	Type	Per Carton	Per Pallet	Total Weight
33 lb	15 kg	Spool		72	2,376 lbs (1078 kg)
60 lb	27 kg	Coil		42	2,520 lbs (1145 kg)
500 lb	249 kg	Drum		2	1,100 lbs (500 kg)



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WELDING PRODUCTS

**Specific
Product
Packaging
Information**

.045" (1.2 mm)	33# (15 kg) spool
1/16" (1.6 mm)	60# (27.2 kg) coil
3/32" (2.4 mm) x	60# (27.2 kg) coil

**Detailed
Packaging
Information**

Pounds	Metric	Type	Per Carton	Per Pallet	Total Weight
33 lb	15 kg	Spool		72	2,376 lbs (1078 kg)
60 lb	27 kg	Coil		42	2,520 lbs (1145 kg)



KISWEL
WELDING PRODUCTS

K-70ST

Specific Product Packaging Information

.045" (1.2 mm)	33# (15 kg) spool
.052" (1.4 mm)	33# (15 kg) spool
1/16" (1.6 mm)	60# (27.2 kg) coil

Detailed Packaging Information

Pounds	Metric	Type	Per Carton	Per Pallet	Total Weight
33 lb	15 kg	Spool		72	2,376 lbs (1078 kg)
60 lb	27 kg	Coil		42	2,520 lbs (1145 kg)



KISWEL
WELDING PRODUCTS

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**Specific
Product
Packaging
Information**

.045" (1.2 mm)	33# (15 kg) spool
.052" (1.4 mm)	33# (15 kg) spool
1/16" (1.6 mm)	60# (27.2 kg) coil

**Detailed
Packaging
Information**

Pounds	Metric	Type	Per Carton	Per Pallet	Total Weight
33 lb	15 kg	Spool		72	2,376 lbs (1078 kg)
60 lb	27 kg	Coil		42	2,520 lbs (1145 kg)



Specific Product Packaging Information

.045" (1.2 mm)	33# (15 kg) spool
	60# (27.2 kg) coil
	500# (227 kg) drum pack
1/16" (1.6 mm)	33# (15 kg) spool
	60# (27.2 kg) coil
	500# (227 kg) drum pack
5/64" (2.0 mm)	60# (27.2 kg) coil
	500# (227 kg) drum pack
3/32" (2.4 mm) x	60# (27.2 kg) coil
	500# (227 kg) drum pack

Detailed Packaging Information

Pounds	Metric	Type	Per Carton	Per Pallet	Total Weight
33 lb	15 kg	Spool		72	2,376 lbs (1078 kg)
60 lb	27 kg	Coil		42	2,520 lbs (1145 kg)
500 lb	249 kg	Drum		2	1,100 (500 kg)



Specific Product Packaging Information

.030" (0.8 mm)	11# (5 kg), 33# (15 kg), 44# (20 kg) spool
.035" (0.9 mm)	10# (4.5 kg), 33# (15 kg) spool
.045" (1.2 mm)	10# (4.5 kg), 33# (15 kg) spool 60# (27.2 kg) coil 500# (227 kg) drum pack
.052" (1.4 mm)	10# (4.5 kg), 33# (15 kg) spool 60# (27.2 kg) coil 500# (227 kg) drum pack
1/16" (1.6 mm)	10# (4.5 kg), 33# (15 kg) spool 60# (27.2 kg) coil 500# (227 kg) drum pack

Detailed Packaging Information

Pounds	Metric	Type	Per Carton	Per Pallet	Total Weight
10 lb	4.5 kg	Spool		200	2,000 lbs (906 kg)
11 lb	5 kg	Spool		200	2,200 lbs (1000 kg)
33 lb	15 kg	Spool		72	2,376 lbs (1078 kg)
44 lb	20 kg	Spool		60	2,640 lbs (1197 kg)
60 lb	27 kg	Coil		42	2,520 lbs (1145 kg)
500 lb	249 kg	Drum		2	1,100 lbs (500 kg)



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**Specific
Product
Packaging
Information**

.035" (0.9 mm)	10# (4.5 kg), 33# (15 kg) spool
.045" (1.2 mm)	10# (4.5 kg), 33# (15 kg) spool 60# (27.2 kg) coil 500# (227 kg) drum pack
1/16" (1.6 mm)	10# (4.5 kg), 33# (15 kg) spool 60# (27.2 kg) coil 500# (227 kg) drum pack

**Detailed
Packaging
Information**

Pounds	Metric	Type	Per Carton	Per Pallet	Total Weight
10 lb	4.5 kg	Spool		200	2,000 lbs (906 kg)
33 lb	15 kg	Spool		72	2,376 lbs (1078 kg)
60 lb	27 kg	Coil		42	2,520 lbs (1145 kg)
500 lb	249 kg	Drum		2	1,100 lbs (500 kg)



Specific Product Packaging Information

.035" (0.9 mm)	10# (4.5 kg), 33# (15 kg) spool
.045" (1.2 mm)	10# (4.5 kg), 33# (15 kg) spool 60# (27.2 kg) coil 500# (227 kg) drum pack
1/16" (1.6 mm)	10# (4.5 kg), 33# (15 kg) spool 60# (27.2 kg) coil 500# (227 kg) drum pack

Detailed Packaging Information

Pounds	Metric	Type	Per Carton	Per Pallet	Total Weight
10 lb	4.5 kg	Spool		200	2,000 lbs (906 kg)
33 lb	15 kg	Spool		72	2,376 lbs (1078 kg)
60 lb	27 kg	Coil		42	2,520 lbs (1145 kg)
500 lb	249 kg	Drum		2	1,100 lbs (500 kg)



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**Specific
Product
Packaging
Information**

.045" (1.2 mm)	10# (4.5 kg), 33# (15 kg) spool
.052" (1.4 mm)	10# (4.5 kg), 33# (15 kg) spool
1/16" (1.6 mm)	10# (4.5 kg), 33# (15 kg) spool

**Detailed
Packaging
Information**

Pounds	Metric	Type	Per Carton	Per Pallet	Total Weight
10 lb	4.5 kg	Spool		200	2,000 lbs (906 kg)
33 lb	15 kg	Spool		72	2,376 lbs (1078 kg)



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**Specific
Product
Packaging
Information**

1/16" (1.6 mm) 33# (15 kg) spool

**Detailed
Packaging
Information**

Pounds	Metric	Type	Per Carton	Per Pallet	Total Weight
33 lb	15 kg	Spool		72	2,376 lbs (1078 kg)

**Specific
Product
Packaging
Information**

.045" (1.2 mm)	10# (4.5 kg), 33# (15 kg) spool
1/16" (1.6 mm)	10# (4.5 kg), 33# (15 kg) spool
5/64" (2.0 mm)	33# (15 kg) spool

**Detailed
Packaging
Information**

Pounds	Metric	Type	Per Carton	Per Pallet	Total Weight
10 lb	4.5 kg	Spool		200	2,000 lbs (906 kg)
33 lb	15 kg	Spool		72	2,376 lbs (1078 kg)



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**Specific
Product
Packaging
Information**

.045" (1.2 mm)	10# (4.5 kg), 33# (15 kg) spool
1/16" (1.6 mm)	10# (4.5 kg), 33# (15 kg) spool
5/64" (2.0 mm)	33# (15 kg) spool

**Detailed
Packaging
Information**

Pounds	Metric	Type	Per Carton	Per Pallet	Total Weight
10 lb	4.5 kg	Spool		200	2,000 lbs (906 kg)
33 lb	15 kg	Spool		72	2,376 lbs (1078 kg)



KISWEL
WELDING PRODUCTS

Tubular Wires
AWS E70C-3M
KX-70CM

Metal Cored

**Specific
Product
Packaging
Information**

.045" (1.2 mm)	10# (4.5 kg), 33# (15 kg) spool
.052" (1.4 mm)	10# (4.5 kg), 33# (15 kg) spool
1/16" (1.6 mm)	10# (4.5 kg), 33# (15 kg) spool

**Detailed
Packaging
Information**

Pounds	Metric	Type	Per Carton	Per Pallet	Total Weight
10 lb	4.5 kg	Spool		200	2,000 lbs (906 kg)
33 lb	15 kg	Spool		72	2,376 lbs (1078 kg)



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WELDING PRODUCTS

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**Specific
Product
Packaging
Information**

.045" (1.2 mm)	33# (15 kg) spool
1/16" (1.6 mm)	33# (15 kg) spool

**Detailed
Packaging
Information**

Pounds	Metric	Type	Per Carton	Per Pallet	Total Weight
33 lb	15 kg	Spool		72	2,376 lbs (1078 kg)



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**Specific
Product
Packaging
Information**

.045" (1.2 mm)	10# (4.5 kg), 33# (15 kg) spool
.052" (1.4 mm)	10# (4.5 kg), 33# (15 kg) spool
1/16" (1.6 mm)	10# (4.5 kg), 33# (15 kg) spool

**Detailed
Packaging
Information**

Pounds	Metric	Type	Per Carton	Per Pallet	Total Weight
10 lb	4.5 kg	Spool		200	2,000 lbs (906 kg)
33 lb	15 kg	Spool		72	2,376 lbs (1078 kg)



KISWEL
WELDING PRODUCTS

Tubular Wires
AWS E70C-6M

Metal Cored

KX-706M Plus

Specific Product Packaging Information

.045" (1.2 mm)	10# (4.5 kg), 33# (15 kg) spool
.052" (1.4 mm)	10# (4.5 kg), 33# (15 kg) spool
1/16" (1.6 mm)	10# (4.5 kg), 33# (15 kg) spool

Detailed Packaging Information

Pounds	Metric	Type	Per Carton	Per Pallet	Total Weight
10 lb	4.5 kg	Spool		200	2,000 lbs (906 kg)
33 lb	15 kg	Spool		72	2,376 lbs (1078 kg)



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WELDING PRODUCTS

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Tubular Wires

Metal Cored

Specific Product Packaging Information

.045" (1.2 mm)	10# (4.5 kg), 33# (15 kg) spool
.052" (1.4 mm)	10# (4.5 kg), 33# (15 kg) spool
1/16" (1.6 mm)	10# (4.5 kg), 33# (15 kg) spool

Detailed Packaging Information

Pounds	Metric	Type	Per Carton	Per Pallet	Total Weight
10 lb	4.5 kg	Spool		200	2,000 lbs (906 kg)
33 lb	15 kg	Spool		72	2,376 lbs (1078 kg)



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Tubular Wires

Stainless Steel

Specific Product Packaging Information

.045" (1.2 mm)	33# (15 kg) spool
1/16" (1.6 mm)	33# (15 kg) spool

Detailed Packaging Information

Pounds	Metric	Type	Per Carton	Per Pallet	Total Weight
33 lb	15 kg	Spool		72	2,376 lbs (1078 kg)



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MIG Wires

Specific Product Packaging Information

.030" (0.8 mm) x	11# (5 kg), 33# (15 kg), 44# (20 kg) spool
.035" (0.9 mm) x	11# (5 kg), 33# (15 kg), 44# (20 kg) spool 550# (259 kg) and 900# (408 kg) drum pack
.040" (1.0 mm) x	33# (15 kg), 44# (20 kg) spool 550# (259 kg) and 900# (408 kg) drum pack
.045" (1.2 mm) x	33# (15 kg), 44# (20 kg) spool 550# (259 kg) and 900# (408 kg) drum pack
.052" (1.4 mm) x	33# (15 kg), 44# (20 kg) spool 550# (259 kg) and 900# (408 kg) drum pack
1/16" (1.6mm) x	33# (15 kg), 44# (20 kg) spool 550# (259 kg) and 900# (408 kg) drum pack

Detailed Packaging Information

Pounds	Metric	Type	Per Carton	Per Pallet	Total Weight
11 lb	5 kg	Spool	5	200	2,200 lbs (1000 kg)
33 lb	15 kg	Spool		72	2,376 lbs (1078 kg)
44 lb	20 kg	Spool		60	2,640 lbs (1197 kg)
550 lb	249 kg	Drum		2	1,100 lbs (500 kg)
900 lb	408 kg	Drum		1	900 lbs (900 kg)



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TIG Wires

Specific Product Packaging Information

.045" (1.2 mm)	10# (5 kg) cartons
1/16" (1.6 mm)	10# (5 kg) cartons
3/32" (2.4 mm)	10# (5 kg) cartons
1/8" (3.2 mm)	10# (5 kg) cartons
5/32" (4.0 mm)	10# (5 kg) cartons
3/16" (5.0 mm)	10# (5 kg) cartons
7/32" (5.6 mm)	10# (5 kg) cartons
1/4" (6.0 mm)	10# (5 kg) cartons

Detailed Packaging Information

Pounds	Metric	Type	Per Carton	Per Pallet	Total Weight
10 lb	5 kg	Carton	6	60	3,000 lbs (1361 kg)



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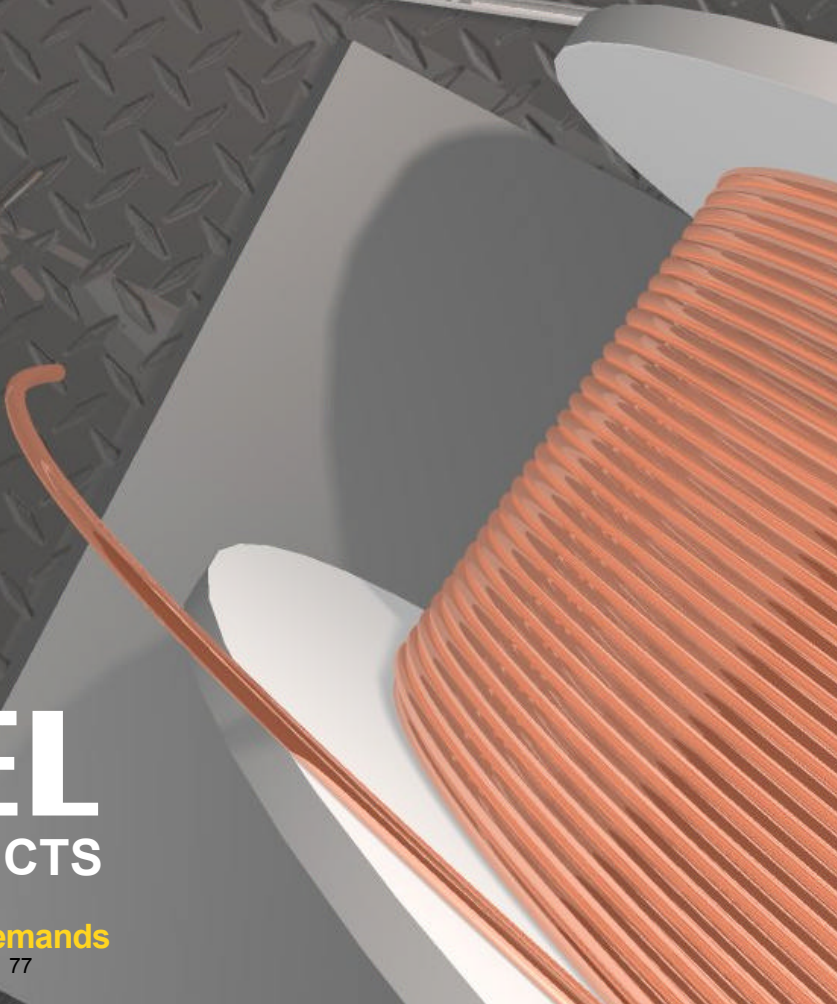
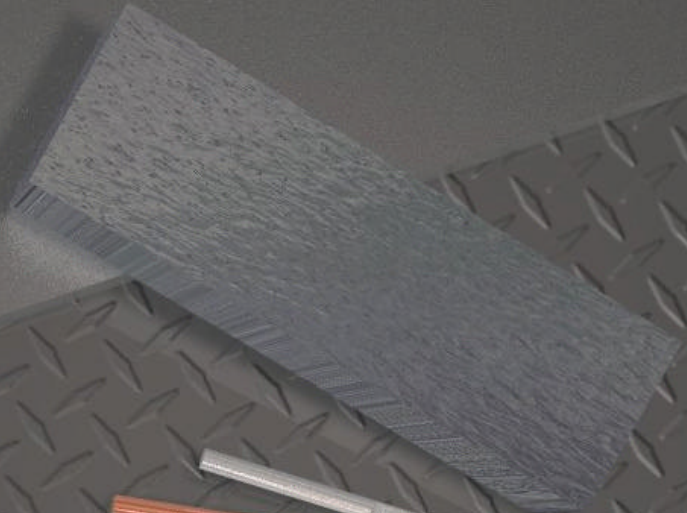
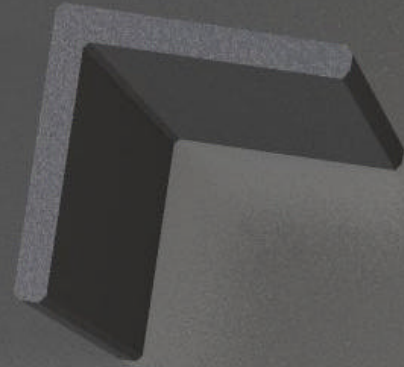
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