

Flux Cored Wire for Stainless Steel

KFW-308LF

Classification

AWS	A5.22	E308LT0-1/4
JIS	Z3323	TS308L-FB0
EN	17633-A	T 19 9 L R C/M3
GB	T 17853	E308LT0-1/4

Shielding Gas: CO₂ or Ar+20%CO₂

Applications and Features

- (1) Weld metal 19.5%Cr-10%Ni, which is suitable for welding 18%Cr-8%Ni stainless steel (AISI 301,302,304,305 and 308).
- (2) It provides excellent weldability and crack resistance due to proper ferrite contents in the weld metal.
- (3) It provides stable arc, good slag removal, and easy control of weld puddle, low spatters, X-ray quality welds and good penetration.
- (4) It has a bright silvery bead appearance and good wettability.

Welding Position

F (IG), H-Fillet (2F)

Welding Instruction

- (1) For other instructions, please refer to Appendix D.
- (2) For extra information, please refer to Appendix F.

Typical Chemical Composition of Weld Metal (wt %) (Shielding Gas : CO₂)

C	Si	Mn	P	S	Cr	Ni
0.036	0.67	1.62	0.034	0.005	19.09	8.81

Typical Mechanical Properties of Weld Metal (Shielding Gas : CO₂)

Tensile Strength N/mm ² (kgf/mm ²)	Elongation %
550(56.1)	42

Size and Suggested Operating Range (DC+)

Diameter (mm)	F/H-fillet		V/OH	
	Amp	Volt	Amp	Volt
1.2	100~300	20~36	100~200	24~30
1.6	200~360	26~40	—	—