Flux Cored Wire for Stainless Steel

KFW-308L

Shielding Gas： 100% CO_2 or Ar+20%CO_2

Classification

AWS	A5.22/A5.22M	E308LT1-1/4
JIS	Z3323	TS308L-FB1
EN	17633-A	T 19 9 L P C1/M21 2
GB	T17853	E308LT1-1/4

Applications and Features

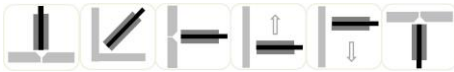
(1) Weld metal is austenitic structure with 18.5% Cr-9% Ni.

(2) Excellent weldability and crack resistance due to proper ferrite content in the weld metal.

(3) Stable arc, good slag removal, low spatters, X-ray quality welds and good penetration.

(4) Suitable for welding austenitic stainless steel, such as AISI 301, 302, 304, 305, and 308.

Welding position



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%)

C	Si	Mn	P	S	Cr	Ni
0.02	0.48	0.92	0.022	0.006	18.71	9.30

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation
N/mm^2	N/mm^2	%
670	416	40

Size and Suggested Operating Range (DC+)

Diameter (mm)		0.9	1.2	1.6
Current	Flat/H-fillet	110~150	150~220	200~300A
(A)	V-up	100~130	130~160	150~180A