

Flux Cored Wire for Stainless Steel

WM-308L

Classification

AWS	A5.22	E308LT1-1/4
JIS	Z3323	TS308L-FB1
EN	17633-A	T 19 9 L P C1/M21 2
GB	T 17853	E308LT1-1/4

Shielding Gas: CO₂ or Ar+20%CO₂

Applications and Features

- (1) Weld deposit is 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 content in the weld metal.
- (3) It provides stable arc, good slag removal, and easy control of the weld puddle, low spatters, X-ray quality welds and good penetration.
- (4) It has flat bead shape and good wettability.

Welding Position

All positions

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
0.037	0.45	1.33	0.025	0.004	19.37	9.87

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

Tensile Strength N/mm ² (kgf/mm ²)	Elongation %
560(57.7)	40

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	—	—