SW-308L Cored

Type : Rutile

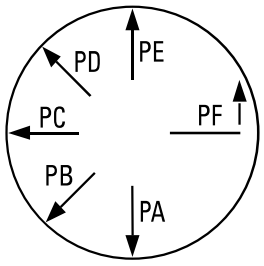
Conformances

AWS	A5.22/ ASME SFA5.22 E308LT1-1/-4
JIS	Z3323 TS308L-FB1
EN	ISO 17633-A-T 19 9 L P M21/C1 2
ABS	AWS A5.22 E308LT1-1 (-120°C 29J)
LR	304L (-120°C)
BV	UP (KV -120°C)
DNV·GL	VL 308L (-120°C)
NK	KW308LG(C)
TÜV	EN ISO 17633-A - T 19 9 L P M21/C1 2
DB	DIN EN ISO 17633-A-T 19 9 L P M21/C1 2
CWB	AWS A5.22 E308LT1-1/4
CE	
RS	A-5(304L) (C1)

Applications

- 18%Cr-8%Ni stainless steel

Welding Position



Features

- Good porosity resistance
- Good performance in all positions

Current

DC +

Shielding Gas

100% CO_2

Ar + 20~25% CO_2

Diameter / Packaging

Diameter	Spool			Pac		
mm (in)	5kg (11lbs)	12.5kg (27.6lbs)	15kg (33lbs)	250kg (551lbs)	300kg (661lbs)	350kg (771lbs)
0.9 (0.035)	√	√	√			
1.0 (0.040)	√	√	√			
1.2 (0.045)	√	√	√			
1.4 (0.052)	√	√	√			
1.6 (1/16)		√	√			

Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	P	S	Cr	Ni	Mo
100% CO_2	0.019	0.76	1.52	0.015	0.010	18.4	10.6	0.02
80% Ar + 20% CO_2	0.019	0.76	1.52	0.015	0.010	18.4	9.66	0.02

Typical Mechanical Properties of All-Weld Metal

	TS MPa(lbs/in²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft·lbs)
100% CO_2	567 (82,215)	48.4	-60 (-76)	53 (39.1)
80% Ar + 20% CO_2	573 (83,085)	48.4	-60 (-76)	54 (39.8)

Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)
1.2mm (0.045 in) DC+					
100% CO_2	20 (4/5)	6.2 (244)	140	23~26	2.6 (5.7)
		9.0 (354)	180	27~30	3.8 (8.4)
		12.0 (472)	210	28~31	4.6 (10.1)
80% Ar + 20% CO_2	20 (4/5)	6.2 (244)	140	23~26	2.7 (5.9)
		9.0 (354)	180	27~30	3.7 (8.3)
		12.0 (472)	210	27~30	4.8 (10.6)
1.6mm (1/16 in) DC+					
100% CO_2	25 (1)	3.7 (146)	180	24~27	3.0 (6.6)
		6.4 (250)	250	25~28	4.5 (9.9)
		8.9 (350)	290	26~29	5.5 (12.1)
80% Ar + 20% CO_2	25 (1)	3.7 (146)	180	24~27	3.1 (6.8)
		6.4 (250)	250	25~28	4.6 (10.1)
		8.9 (350)	290	26~29	5.7 (12.6)