

# Supercored 308L

Type : Rutile



## Conformances

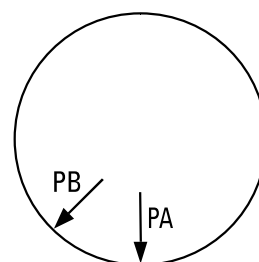
AWS A5.22/ ASME SFA5.22 E308LT0-1/-4  
 JIS Z3323 TS308L-FB0  
 EN ISO 17633-A-T 19 9 L R M21/C1 3  
 TÜV EN ISO 17633-A-T 19 9 L R M21/C1 3  
 DB DIN EN ISO 17633-A-T 19 9 L R M21/C1 3

CE

## Applications

- 18%Cr-8%Ni stainless steel

## Welding Position



## Features

- Flat and horizontal fillet position welding
- High deposition rate and efficiency

## Current

DC +

## Shielding Gas

100% CO<sub>2</sub>  
 Ar + 20~25% CO<sub>2</sub>

## Diameter / Packaging

Diameter	Spool			Pac		
	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)	✓	✓	✓			
1.6 (1/16)		✓	✓			

## Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	P	S	Cr	Ni	Mo
100% CO <sub>2</sub>	0.03	0.50	1.50	0.02	0.01	19.0	9.5	0.05
80% Ar + 20% CO <sub>2</sub>	0.03	0.60	1.60	0.02	0.01	19.5	9.6	0.05

## Typical Mechanical Properties of All-Weld Metal

	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft·lbs)	Ferrite Number
100% CO <sub>2</sub>	550 (79,750)	44	-20 (-4)	50 (37)	7-10
80% Ar + 20% CO <sub>2</sub>	570 (82,650)	43	-20 (-4)	55 (41)	7-10

## 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)
<b>1.2mm (0.045 in) DC+</b>					
100% CO <sub>2</sub>	20 (4/5)	6.2 (244)	140	23~26	2.7 (6.0)
		9.0 (354)	180	27~30	3.9 (8.6)
		12.0 (472)	210	28~31	5.0 (11.0)
80% Ar + 20% CO <sub>2</sub>	20 (4/5)	6.2 (244)	140	23~26	2.8 (6.2)
		9.0 (354)	180	27~30	4.0 (8.8)
		12.0 (472)	210	27~30	5.1 (11.2)
<b>1.6mm (1/16 in) DC+</b>					
100% CO <sub>2</sub>	25 (1)	3.7 (146)	180	24~27	3.0 (6.6)
		6.4 (250)	250	25~28	4.8 (10.6)
		8.9 (350)	290	26~29	6.3 (13.9)
80% Ar + 20% CO <sub>2</sub>	25 (1)	3.7 (146)	180	24~27	3.1 (6.8)
		6.4 (250)	250	25~28	5.0 (11.0)
		8.9 (350)	290	26~29	6.5 (14.3)