

S-300B X YS-308L [YS-309L, YS-316L, YS-347]

Type : Neutral

Conformances

JIS Z3352 SA AF2
EN ISO 14174-S A AF 2

Applications

- 18%Cr-8%Ni , 22%Cr-12%Ni , 18%Cr-12%Ni-2%Mo stainless steel

Features

- Good resistance to crack and corrosion
- Easy to remove slag
- Good bead appearance
- Density : 1.2g/cm³

Current

AC, DC +

Basicity Index

1.7

Packages (Flux)

Tin Can 20kg(44lbs)
PE Bag 20kg(44lbs)

Flux Composition

Consumable	Chemical Composition, wt%			
	SiO ₂ + TiO ₂	Al ₂ O ₃ + MnO	MgO + CaO	CaF ₂
S-300B	10	35	3	45

SMW

SAW

GMW

GTAW

FCAW

Non-FERROUS

APPENDIX

S-300B X YS-308L [YS-309L, YS-316L, YS-347]

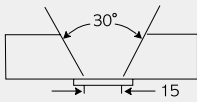
Typical Chemical Composition of All-Weld Metal(%)

Wire	C	Si	Mn	Cr	Ni	Mo	Nb
YS-308L	0.03	0.70	1.80	19.2	9.8		
YS-309L	0.03	0.70	1.80	23.8	12.6		
YS-316L	0.03	0.70	1.60	18.3	11.6	2.1	
YS-347	0.05	0.60	1.30	18.7	8.6		0.60

Typical Mechanical Properties of All-Weld Metal

Wire	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.lbs)
YS-308L	600 (87,000)	42	-196 (-321)	40 (30)
YS-309L	570 (82,700)	38		
YS-316L	580 (84,200)	38		
YS-347	660 (95,000)	41	-196 (-321)	40 (30)

Typical Welding Parameters

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks
YS-308L YS-309L YS-316L YS-347	4.0	20		1~10	550	32 30	50	JIS Z3324