K-308LT

Austenitic Stainless welding wire (Low C, 18%Cr-8%Ni)

Classifications

EN ISO 17633-A:2008	: T 19 9 L P C(M) 1	KS D 3612	: YF-308LC
EN ISO 17633-B:2008	: TS308L-FB1	JIS Z 3323	: TS308L-FB1
AWS A5.22-15	: E308LT1-1/4		

Description

- K-308LT is designed for MAG welding of low carbon 18%Cr-8%Ni stainless steel and used to joint austenitic stainless steel (AISI 304, 304L, 304LN, ASTM A157 Gr. C9; A320 Gr. B8C or D)
- The weld metal contains optimum ferrite contents in their austenitic structures, Therefore their weldability is excellent with lower crack susceptibility.
- It has easy slag removal, low spatter generation and good weld soundness of weld-metal.

Welding positions

Polarity & shielding gas

- CO_2: 100% CO_2 (15~25ℓ/min)
  Mix: Ar+20% CO_2 (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	Cr	Ni	FN
CO_2	0.03	0.60	1.15	20.30	10.50	3~8 & 8~12
Mix	0.03	0.65	1.25	20.40	10.50	

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -40℃	Remarks
AWS A5.22		min. 520	min. 35		
EN ISO 17633-B		min. 520	min. 30		
Example	440	570	39	65	CO_2
	450	580	38	63	Mix

Notes on usage and welding condition

- Refer to page 303 for more information on usage
- When heat input is excessive, base metal will be bended or distorted due to the bad heat conductivity. Therefore, perform welding with selecting proper heat input

Package

Dia. (mm)	0.9	1.2	1.6
Spool (kg)	5, 12.5, 15		

Approvals

Shielding gas	ABS	BV	DNV	LR	NK	KR	CCS
CO_2	E308LT1-1	UP	308L	BF 304L S CHE	KW 308LG(C)	RW 308LG(C)	304L