

SW-308L Cored

Type : Rutile



Conformances

AWS A5.22 / ASME SFA5.22 E308LT1-1/-4
 JIS Z3323 TS308L-FB1
 EN ISO 17633-A-T 199 L P M/C 2
 ABS AWS A5.22 E308LT1-1 (-120°C 29J)
 LR 304L (-120°C)
 BV UP (KV -120°C)

DNV 308L (-120°C)
 NK KW308LG(C)
 TÜV EN ISO 17633-A-T 199 L P M21/C1 2
 CWB AWS A5.22 E308LT1-1/4
 CE
 DB DIN EN ISO 17633-A-T 199 L P M/C 2

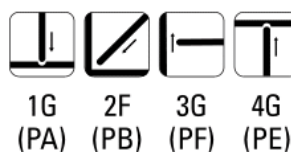
Applications

- 18%Cr-8%Ni stainless steel

Features

- Good porosity resistance
- Good performance in all positions

Welding Position



Current

DC +

Shielding Gas

100% CO₂
 Ar + 20~25% CO₂

Diameter / Packaging

Diameter mm (in)	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)	✓	✓	✓			
1.4 (0.052)	✓	✓	✓			
1.6 (1/16)		✓	✓			

SM/AW

SAW

GM/AW

GT/AW

FC/AW

Non-FERROUS

APPENDIX

Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	P	S	Cr	Ni	Mo
100% CO ₂	0.03	0.70	1.40	0.02	0.01	19.0	9.6	0.05
80% Ar + 20% CO ₂	0.03	0.80	1.50	0.02	0.01	19.5	9.7	0.05

Typical Mechanical Properties of All-Weld Metal

	TS Mpa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)	Ferrite Number
100% CO ₂	550 (79,750)	44	-20 (4)	60 (44)	8-11
80% Ar + 20% CO ₂	560 (81,200)	43	-20 (4)	50 (37)	8-11

Typical Operating Procedures

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Voltage (volts)	Approx. Current (amps)	Deposition Rate kg/hr (lb/hr)
1.2mm (0.045 in) DC+					
100% CO ₂	20 (4/5)	6.2 (244)	23-26	140	2.6 (5.7)
		9.0 (354)	27-30	180	3.8 (8.4)
		12.0 (472)	28-31	210	4.6 (10.1)
80% Ar + 20% CO ₂	20 (4/5)	6.2 (244)	23-26	140	2.7 (5.9)
		9.0 (354)	27-30	180	3.7 (8.3)
		12.0 (472)	27-30	210	4.8 (10.6)
1.6mm (1/16 in) DC+					
100% CO ₂	25 (1)	3.7 (146)	24-27	180	3.0 (6.6)
		6.4 (250)	25-28	250	4.5 (9.9)
		8.9 (350)	26-29	290	5.5 (12.1)
80% Ar + 20% CO ₂	25 (1)	3.7 (146)	24-27	180	3.1 (6.8)
		6.4 (250)	25-28	250	4.6 (10.1)
		8.9 (350)	26-29	290	5.7 (12.6)