K-308LT

FLUX CORED ARC WELDING
CONSUMABLE FOR
AUSTENITIC STAINLESS STEEL

KISWEL

Description

- K-308LT is designed for MAG welding of low carbon 18%Cr-8%Ni stainless steel and used to joint austenitic stainless steel.
- 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.

Classification

- EN ISO 17633 A : T 19 9 L P C1/M21 1
- EN ISO 17633 B : TS 308L-F C1/M21 1
- AWS A5.22 : E308LT1-1/4

Typical Chemical Composition of Weld metal (wt.%)

	C	Si	Mn	Cr	Ni	Mo	FN
AWS A5.22	<0.04	<1.0	0.5-2.5	18.0-21.0	9.0-11.0	<0.75	-
100%CO_2	0.03	0.65	1.00	20.30	10.50	0.04	3~10
80%Ar+20%CO_2	0.03	0.72	1.12	20.40	10.50	0.04	3~10

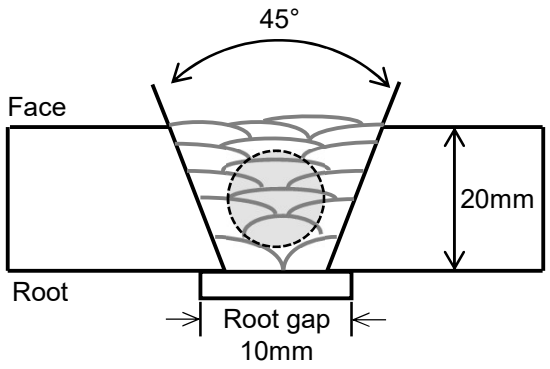
Shielding Gas

- 100%CO_2 (15~25ℓ/min)

Welding position



All Weld Metal Test Specimen



Base metal	SM490(Buttering)
Diameter	1.2mm
Current / Voltage	200A / 31V
Stick out	20mm
Travel Speed	32 CPM
Welding Position	PA / 1G

Typical Mechanical Properties of Weld metal

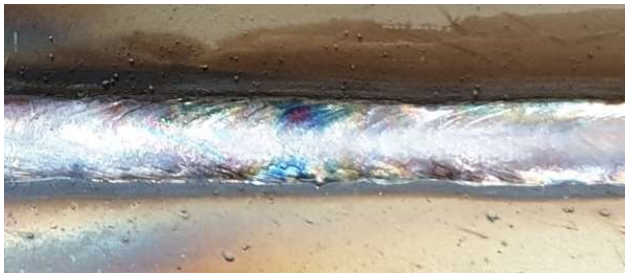
	Y.S (MPa)	T.S (MPa)	El. (%)	I.V (J) @ -40℃	Shielding Gas
AWS A5.22	-	>520	>30	-	CO_2
K-308LT	419	562	42	51	

Optimum Welding Conditions

Current (A)	160	200	240
Voltage (V)	28	31	34

■ Bead appearance

H-Fillet



Vertical up



■ Packaging (Size and Weight)



Dia. (mm)	0.9, 1.0, 1.2, 1.4, 1.6
Weight (kg)	5, 12.5, 15
Pail pack(kg)	-

■ Handling and Storage

- **Once flux cored wire picked up moisture, it cannot be dried at high temperature, unlike covered electrode.**
- **If a wire was left in a wire feeder in a high-temperature high - humidity atmosphere in summer season, a wet environment in rainy season or a dew fall environment at night in winter was unpacked, the wire should be kept in an area of low humidity.**

  ※ Temp. below 30℃ relative humidity below 60%

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