Flux Cored Welding Wire

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

K-30

Classifications

EN ISO 17633-B:2010 : TS 308H-F C1/M21 1 JIS Z 3323-2007 : TS308H-FB1 AWS A5.22-2012 : E308HT1-1/4

Description

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- K-308HT is designed for MAG welding of high carbon 18%Cr-8%Ni stainless steels(STS 304H, 307H) and recommended to be use for high temperature service (about 600°C)
- It is a titania type of flux cored wire for all-position welding and has excellent feedability and increased creep resistance at elevated temperature.
- The weld metal contains optimum ferrite contents in their austenitic micro structures and their weldability is excellent with lower crack susceptibility.

Welding positio	ns		
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Polarity & shielding gas

 CO2: 100% CO2 (15~25ℓ/min) Mix: Ar+20% CO2 (15~25ℓ/min)
DCEP (DC+)

Typical chemical composition of all-weld metal (%)						
Shielding gas	С	Si	Mn	Cr	Ni	FN
CO ₂	0.06	0.65	1.00	19.50	10.50	7.5
Mix	0.06	0.75	1.10	19.80	10.50	8.0

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	EI. (%)	IV (J) -40℃	Remarks
AWS A5.22 EN ISO 17633-B		min. 520 min. 520	min. 35 min. 30		
Example	430	600	39	45	CO2
	440	610	40	55	Mix

Packago

Notes on usage and welding condition

- · Refer to page 313 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 inp

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

Approvals

JIS

* Please refer to our homepage(www.kiswel.com) for further detailed information regarding approvals.

