K-308LB

Austenitic Stainless welding wire (Low C, Bi Free)

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-BiF-FB1
AWS A5.22-15	: E308LT1-1/4		

Description

- K-308LB is designed for MAG welding of high carbon 18%Cr-8%Ni stainless steels with high temperature heat treatment such as solution treatment.
- It is a titania type of flux cored wire without Bi component for all-position welding.
- It has excellent feedability and increased creep resistance at elevated temperature.

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	0.48	1.15	19.30	9.95	7.5
Mix	0.03	0.60	1.25	19.50	10.00	8.0

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	420	560	38	56	CO_2
	430	580	38	52	Mix

Notes on usage and welding condition

- Refer to page 303 for more information on usage
- It should weld with proper welding conditions for slag detachment and weldability.

Package

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