

Gas Shielded Type Flux Cored Wire

KF308L

AWS A5.22 E308LT1-1/4
JIS Z 3323 TS308L-FC1

Product Features:

- Rutile type gas shield flux cored arc welding wire, austenite structure weld metal.
- Smooth arc, low spatter loss and easy slag removal.
- Low carbon content in weld metal to get good crack and inter-granular corrosion resistance.
- Good bead appearance.
- Easy to get Smooth fillet weld size.

Applications:

- Suitable for welding of stainless steels such as SUS301, 302, 304, 304L and 305.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Ni	Cr
0.03	0.60	1.59	9.870	19.180

Typical mechanical properties of all weld metal

Tensile Strength N/mm ²	Elongation %
573	39.3

Size (mm) & recommended welding parameters

Diameter		1.2mm	1.6mm
Polarity		DC+	DC+
Ampere (A)	Flat / Horizontal position	150~250	200~300
	Vertical / overhead position	100~140	----
Shielding Gas		CO ₂ / Mixed Gas	CO ₂ / Mixed Gas

Note:

- Use general CO₂ welding machine with proper feed roller pressure.

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