

For Low Carbon 18% Cr-8% Ni Stainless Steel

APPLICATIONS

Welding of low carbon 18%Cr-8%Ni stainless steel for chemical apparatus, containers and plants.

CHARACTERISTICS

SF-308L is a seamless flux cored arc welding wire to be used with CO₂ or Ar+ more than 20%CO₂ shield gas. Spatters are few, slag is easy to remove and bead appearance and shape are excellent. It is highly resistant to moisture absorption and wire feeding is smooth since the wire has no seam. High welding efficiency is assured in flat and horizontal fillet positions.

GUIDELINES FOR USAGE

1. Distance between base metal and tip should be kept within the range of 15~25mm.
2. Shield gas flow rate should be kept within 20~25ℓ/min.

WELDING POSITION



■ TYPICAL CHEMICAL COMPOSITION OF WELD METAL (%)

Shield Gas	C	Si	Mn	P	S	Ni	Cr
CO ₂	0.033	0.59	1.51	0.024	0.008	10.7	19.9

■ TYPICAL MECHANICAL PROPERTIES OF WELD METAL

Tensile Strength, MPa	Elongation, %
550	41

■ SIZES & RECOMMENDED CURRENT RANGE<DC(+)>

Diameter (mm)	0.8	0.9	1.2	1.6
Current (A)	50~150	70~170	100~250	200~350