

Supercored 308L

TYPE : Rutile

AWS A5.22/ASME SFA5.22 E308LT0-1/-4
JIS Z3323 TS308L-FB0
EN ISO 17633-A-T 19 9 L R M/C 3

Applications

Supercored 308L is designed for use in petrochemical processing, textile industries and can be used for welding 18%Cr-8%Ni stainless steels.

Characteristics on Usage

Supercored 308L for welding stainless steels has a rapid solidifying slag which enables flat and horizontal position welding. It gives a stable arc and low spatter.

Notes on Usage

① Use with 100% CO₂ or Ar + 20~25% CO₂ gas.

Welding Position



1G (PA) 2F (PB)

Current

DC +

Shielding Gas

CO₂/Ar+20~25%CO₂

Typical Chemical Composition of All-Weld Metal (%) (Shielding Gas: 100% CO₂)

C	Si	Mn	P	S	Cr	Ni
0.03	0.70	1.50	0.025	0.010	19.5	9.5

Typical Mechanical Properties of All-Weld Metal (Shielding Gas: 100% CO₂)

TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
600 (87,000)	43	-20 (-4)	60 (44)

Approval

TÜV, CE, DB

I Packing(Including Ball Pac)

Dia. (mm)	0.9	1.2	1.6	Spool(kg)	5	12.5	15
(in)	.035	.045	1/16	(lbs)	11	28	33

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	0.9 (.035)	1.2 (.045)	1.6 (1/16)
F&HF	120~180	150~220	240~300