

FLUX CORED WIRE : STAINLESS STEEL

SARTHAK SS 308L (E 308LT1-1)

AWS-A/SFA5.22E308LT1-1

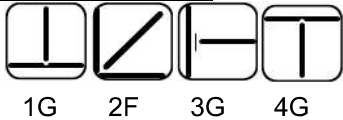
Applications

SARTHAK SS 308L (E 308LT1-1) is used for welding of 18%Cr, 9% Nickel Steel for joining Austenitic Steels such as 304, 304 L, 321, CF -8, CF -3

Characteristics on Usage

SARTHAK SS 308L (E 308LT1-1) is an extra low carbon Lime Titania all position 19% Cr - 10 % Ni stainless steel gas shield flux cored wire. The weld deposit is highly resistance intergranular corrosion, cracking, oxidation and scaling. It gives uniform and fine rippled bead characterized by excellent all around performance and mechanical properties. Weld metal is of radiographic quality with easy slag removal and low spatters

Welding Positions



Recommended Stick Out

15-20mm.

Shielding Gas

Carbon Dioxide (CO₂) shielding

Chemical Composition Of Weld Metal

| Element | C% | Mn% | Si% | S% | P% | Cr % | Ni % | Mo % | Cu % |
|----------------|-------|----------|-----------|-----------|-----------|-----------|--------------|----------|----------|
| Typical Values | 0.030 | 1.50 | 0.60 | 0.010 | 0.030 | 19.80 | 9.50 | 0.050 | 0.10 |
| Spec. Reqd. | 0.040 | 0.5-2.50 | 0.010 Max | 0.030 Max | 0.040 Max | 18-21 Max | 9.0-11.0 Max | 0.50 Max | 0.50 Max |

Mechanical Properties Of Weld Metal

| Property | U.T.S. (N/mm ²) | ELONGATION (L = 4d) % |
|----------------|--------------------------------|----------------------------|
| Typical Values | 580 | 40 |
| Spec. Reqd. | 520 min | 35 Min |

Welding Parameters (DC + VE)

| Diameter (mm) | Flat | | Vertical - Up | | Overhead | |
|------------------|---------|-------|---------------|-------|----------|-------|
| | (A) | (V) | (A) | (V) | (A) | (V) |
| 1.20 | 160-210 | 26-30 | 120-210 | 22-26 | 160-210 | 26-30 |
| 1.60 | 190-250 | 26-30 | 160-250 | 21-27 | 190-250 | 26-30 |

Packing

12.5 kgs. vacuum packed plastic spool.