

E308LT1-1

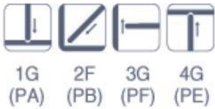
AWS A5.22 E308LT1-1/4

EN ISO 17633-A : T 19 9 L P C1 2

Description:

E308LT1-1 is a super low carbon stainless steel gas shielded flux-cored wire designed for all positional welding, can be used for joining stainless steel alloys such as types AISI 301, 302, 304, 305, and 308. Its deposited metal with excellent mechanical properties and intergranular corrosion resistance.

Welding Position:



Diameters:

0.8mm, 0.9mm, 1.0mm, 1.2mm, 1.6mm

Typical Mechanical Properties:

Tensile strength(MPa):	580
Yield strength(MPa):	--
Elongation(%):	46

Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	Cu
0,035	1,60	0,020	0,015	0,60	9,5	19,2	0,01	0,02

Welding Current:(DC+)

Diameter(mm)	1,2	1,6
Current/A	120-220	180-300
Voltage/V	20-32	20-32
Gas speed/(L/Min)	20-25	20-25

Note:

- 1.Shield gas: 100% CO₂ or 80% Ar+20% Co₂ .
2. Preheat before welding.
3. Interpass temperature: ≤80 °C