

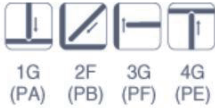
E308LT1-3

AWS A5.22 E308LT1-3

Description:

It is self-shielded, flux cored, stainless steel wire is designed with a nominal weld metal composition of 21% chromium and 10% nickel with a maximum carbon content of .03%. The low carbon in E308LT0-3 minimizes carbide precipitation and makes the weld metal more resistant to intergranular corrosion.

Welding Position:



Diameters:

0.9mm, 1.0mm, 1.2mm

Typical Mechanical Properties:

Tensile strength(MPa):	585
Yield strength(MPa):	--
Elongation(%):	43

Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	Cu
0.035	1.60	0.020	0.015	0.60	9.5	20.3	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

Note:

- 1.Shield gas: none
2. Preheat before welding.
3. Interpass temperature: $\leq 80^{\circ}\text{C}$