

CHARACTERISTICS

- 1, No shielding gas needed
- 2, Ideal for surfacing or welding over gaps
- 2, Good weldability with stable arc and low spatter
3. Uniform and bright bead

TYPICAL APPLICATIONS

- 1, welding of 301, 302, 304L, 308 and 308L stainless steel
- 2, Cladding of carbon steels



SIZE

0.9mm

1.2mm

AMPS

110-175A

120-190A

CLASSIFICATION

AWS A5.22 E308LT0-3
EN ISO 17633-A:T 19 9 L R M 3

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G

EQUIVALENT TO

CHEMICAL COMPOSITIONS (Wt%), ALL WELD METAL, TYPICAL

C	Mn	Cr	Si	Ni
0.03	1.08	20.52	0.7	9.66

AVAILABLE SIZES (DIA.)

1.2mm, 0.9mm

PACKAGING DETAILS

1/5/15kg Spools

CURRENT TYPE

DC+

MECHANICAL PROPERTIES, ALL WELD METAL, TYPICAL

Condition	Yield strength	Tensile strength	Elongation(%)
AW	407 MPa	566 MPa	40%

