

CHARACTERISTICS

- 1, Excellent weldability with stable arc, less spatter
- 2, Uniform bead formation
- 3, Excellent wire feeding performance and high deposition rates

TYPICAL APPLICATIONS

- 1, Suitable for welding of low carbon 18%Cr-8%Ni Austenitic stainless steel(SUS 301, 304(L), 308(L))
- 2, Pressure vessels, tanks used in dairy, pulp and paper, textile dyeing, refinery and chemical equipment
- 3, Especially suitable for automatic welding of H-fillet



SIZE

1.2mm

AMPS

160-220A

CLASSIFICATION

AWS A5.22 E308LT1-1/4
EN ISO 17633-A-T 19 9 L P C/M 1

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G

EQUIVALENT TO

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

C	Si	Mn	P	S	Ni	Cr
0.028	0.60	1.61	0.012	0.01	10.10	19.42

AVAILABLE SIZES (DIA.)

1.2mm

PACKAGING DETAILS

5/15kg Spools

CURRENT TYPE

DC+

MECHANICAL PROPERTIES, ALL WELD METAL, TYPICAL

Condition	Shielding Gas	Yield Strength (mpa)	Tensile Strength (mpa)	Elongation(%)
AW	100% CO2 or 80% Ar+20% CO2	527	590	42

Note:
Shielding gas: Gas speed 15-25L/Min

