

# RAAJCORED308L

## STAINLESS STEEL GAS SHIELDED FLUX CORED ARC WELDING WIRE

**Classification** : AWS: A5.22 E308L-T1  
JIS Z 3323 TS308L-FC1

**Description** : Rutile type Gas shielded Flux cored arc stainless steel welding wire, austenitic structure weld metal, smooth and stable arc, low spatter loss and easy slag remove. Low carbon content in weld metal to get good crack and inter-granular corrosion resistance. Good bead appearance, easy to get smooth fillet size,

**Typical Application** :

- Suitable for welding 18/8 Cr/Ni steel such as SUS301, 302, 304 & 304L and 305 steel.

### TYPICAL ALL WELD CHEMICAL COMPOSITION (Wt. %)

C	Mn	Si	Ni	Cr
0.030	1.59	0.60	9.87	19.18

### TYPICAL ALL WELD MECHANICAL PROPERTIES:

UTS (N/mm <sup>2</sup> )	Elongation %
573	39.3

### DIEMENSION, CURRENT CONDITION & RECOMANDED PARAMETERS

Size (mm) Dia		1.20	1.60
Polarity		DC+	DC+
Ampere(A)	Flat and Horizontal position	150~250	200~300
	Vertical/overhead position	100~140	-----
Shield Gas		CO <sub>2</sub>	CO <sub>2</sub>

Note: - Use General CO<sub>2</sub> Welding Machine with proper feed Roller pressure.