

Classifications

EN ISO 17633-A:2008	: T 19 9 L P C(M) 1	KS D 3612	: YF-308LC
EN ISO 17633-B:2008	: TS308L-FB1	JIS Z 3323	: TS308L-FB1
AWS A5.22-15	: E308LT1-1/4		

Description

- K-308LS is designed for MAG welding of low carbon 18%Cr-8%Ni stainless steels and recommended to be used for low temperature service (STS 304, 304L, 304LN, ASTM A157 Gr C9; A320 Gr. B8C or D)
- It is a titania type of flux cored wire for all-position welding and formulated to focus on mechanical properties more than welding arc stability and provides good corrosion resistance, heat resistance properties.
- The weld metal contains low ferrite contents in their austenitic micro structures and provides good corrosion resistance, heat resistance properties.

Welding positions**Polarity & shielding gas**

- CO₂: 100% CO₂
- Mix: Ar+20% CO₂ (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	Cr	Ni	FN
CO ₂	0.03	0.63	1.39	18.55	10.02	3~8
Mix	0.03	0.69	1.24	18.95	10.86	

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -196°C	Remarks
AWS A5.22		min. 520	min. 35		
EN ISO 17633-B		min. 520	min. 30		
Example	400	550	43	40	CO ₂
	427	587	50	48	Mix

Notes on usage and welding condition

- Refer to page 303 for more information on usage
- When heat input is excessive, the impact value tends to be reduced. Therefore, perform welding with selecting proper heat input

Package

Dia. (mm)	0.9	1.2	1.6
Spool (kg)	5, 12.5, 15		