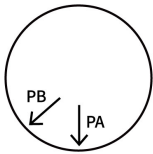


Supercored 308L

Classification

AWS AWS A5.22/ ASME SFA-5.22 E308LTO-1/-4
JIS Z 3323 TS308L-FB0
EN ISO 17633-A-T 19 9 L R M21/C1 3

Welding Positions



Features

- Flat and horizontal fillet position welding
- High deposition rate and efficiency

Polarity

DC +

Application Areas

- 18%Cr-8%Ni stainless steel

Shielding Gas

100% CO2
Ar+20~25% CO2

Approvals

CE	DB	TUV
✓	✓	✓

Typical Chemical Composition of All-Weld Metal (wt%)

Shielding Gas	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	Nb
100% CO2	0.03	0.4	1.3	0.021	0.006	0.11	9.7	19.6	0.10	0.04
Ar+20% CO2	0.03	0.4	1.4	0.021	0.006	0.11	9.6	20.0	0.10	0.04

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
100% CO2	563(82)	41	-60(-75)	39(28)
Ar+20~25% CO2	569(83)	41	-60(-75)	39(28.8)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)	Packaging
0.9(0.035)	160~220	Spool 5kg(11lbs), 12.5(27.6lbs), 15kg(33lbs)
1.6(1/16)	250~290	

SMW

GMW

GTW

FCW

Metal-cored Wire

SAW Wire

SAW Flux