

FOR STAINLESS STEEL

AWS E308LT0-1/4
JIS YF308LC
KS YF308LC

K-308LF

Typical applications

K-308LF is designed for MAG welding of low carbon 18%Cr-8%Ni stainless steel and used to join 301, 302, 304 and 308 stainless steel. It is designed for operation primarily in the flat position and for welding horizontal fillet welds

Characteristics on Usage

- ① Wire is a titania type of flux cored wire for flat and horizontal position welding.
- ② It has self-detaching slag and spray-like arc transfer.
- ③ It provides low spatter and fume, high efficient weld in flat position as well as horizontal.
- ④ The weld metal contains optimum ferrite contents in their austenitic structures, Therefore their weldability is excellent with lower crack susceptibility.
- ⑤ The shielding gas should be used 100%CO₂ and 80%Ar+20%CO₂ for welding.
- ⑥ Refer to page 150 for more information on usage.

Typical chemical composition of all-weld-metal (%)

Shielding Gas	C	Si	Mn	Cr	N i
CO ₂	0.03	0.52	1.70	20.3	10.4
Ar+20%CO ₂	0.03	0.70	1.80	20.5	10.5

Typical mechanical properties of all-weld-metal

Shielding Gas	T · S N/mm ² {kgf/mm ² }	El (%)
CO ₂	620 {63}	38
Ar+20%CO ₂	630 {64}	36

Sizes available and recommended currents (DC wire⊕)

Dia. (mm)	Amp.	Electrode extension (mm)
1.2	100~220	10~20
1.6	160~260	15~20

Welding positions



Approved by
JIS