

# K-308LT

**AWS E308LT1-1/4**  
**JIS YF308LC**  
**KS YF308LC**

FOR STAINLESS STEEL

## Typical applications

K-308LT is designed for MAG welding of low carbon 18%Cr-8%Ni stainless steels. (AISI 304, 304L, 304LN, ASTM A157 Gr. C9; A320 Gr. B8C or D)

## Characteristics on Usage

- ① Wire is a titania type of flux cored wire for all-position welding.
- ② Excellent weldability and increased creep resistance at elevated temperature
- ③ The weld metal contains optimum ferrite contents in their austenitic structures  
Therefore their weldability is excellent with lower crack susceptibility.
- ④ The shielding gas should be used 100%CO<sub>2</sub> and 80%Ar+20%CO<sub>2</sub> for welding.
- ⑤ Refer to page 150 for more information on usage.

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

Shielding Gas	C	Si	Mn	Cr	Ni
CO <sub>2</sub>	0.03	0.62	1.56	19.5	10.5
Ar+20%CO <sub>2</sub>	0.03	0.79	1.90	19.8	10.2

## Typical mechanical properties of all-weld-metal

Shielding Gas	T · S N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	EI (%)
CO <sub>2</sub>	570 {58}	38
Ar+20%CO <sub>2</sub>	610 {62}	35

## Sizes available and recommended currents (DC wire⊕)

Dia. (mm)	Amp.	Electrode extension (mm)
1.2	100~220	10~20
1.6	160~260	15~25

## Welding positions



## Approved by

ABS, BV, CWB, KR, NK, TÜV, JIS  
 (80%Ar+20%CO<sub>2</sub>:CWB, TÜV)