

FOR STAINLESS STEEL

AWS E308T0-1/4  
JIS YF308C  
KS YF308C

# K-308T

## Typical applications

K-308T is formulated for MAG welding of 18%Cr-8%Ni stainless steels. It is designed for operation primarily in the flat position and for welding horizontal fillet welds

## Characteristics on Usage

- ① K-308T is a titania type of flux cored wire for AISI 304 type
- ② Wire has low spatter, easy slag removal and good weld soundness.
- 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>	0.05	0.60	1.55	19.5	10.5
Ar+20%CO <sub>2</sub>	0.04	0.75	1.87	19.7	10.3

## Typical mechanical properties of all-weld-metal

Shielding Gas	T · S	EI
	N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	(%)
CO <sub>2</sub>	580 {59}	38
Ar+20%CO <sub>2</sub>	610 {62}	36

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

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

## Welding positions



## Approved by

ABS, BV, DNV, KR, NK, JIS