

K-308T

Austenitic Stainless welding wire (18%Cr-8%Ni)

Classifications

EN ISO 17633-B:2008	: TS308-FB0	KS D 3612	: YF-308C
AWS A5.22-15	: E308T0-1/4	JIS Z 3323	: TS308-FB0

Description

- K-308T is designed for MAG welding of 18%Cr-8%Ni stainless steels and also formulated for operation primarily in the flat position and for welding horizontal fillet welds.
- It is a titania type of flux cored wire for AISI 304 and 304H steel type and has low spatter generation, easy slag removal and good weld soundness.
- The weld metal contains optimum ferrite contents in their austenitic structures, Therefore their weldability is excellent with lower crack susceptibility.

Welding positions



Polarity & shielding gas

- CO₂: 100% CO₂ (15~25ℓ/min)
- 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	0.04	0.60	1.15	20.40	10.60	9
Mix	0.04	0.65	1.25	20.60	10.60	10

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -40°C	Remarks
AWS A5.22		min. 550	min. 35		
EN ISO 17633-B		min. 550	min. 30		
Example	450	580	39	60	CO ₂
	460	590	38	65	Mix

Notes on usage and welding condition

- Refer to page 303 for more information on usage
- When heat input is excessive, base metal will be bended or distorted due to the bad heat conductivity. Therefore, perform welding with selecting proper heat input

Package

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