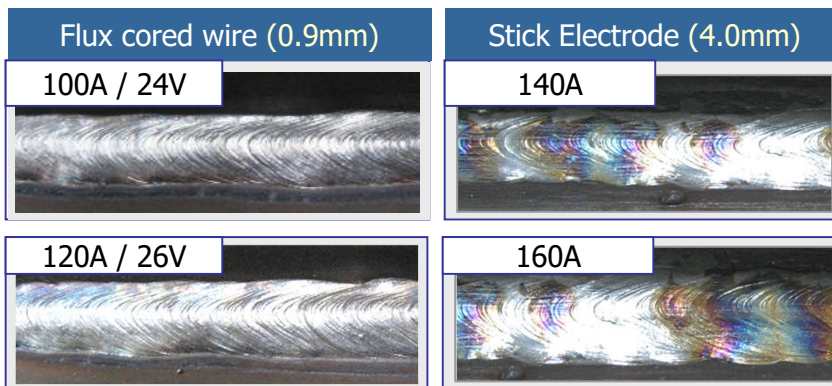


## ■ Applications

Self-shielded welding of low carbon

18%Cr-8%Ni stainless steel



## ■ Characteristics

- ① Wire is a lime-titania type of flux cored wire for flat and horizontal welding position.
- ② It features easy slag removal, open transfer, low spatter generation, smooth bead surface and high X-ray safety.
- ③ The weld metal contains low ferrite contents in their austenitic micro structures and provides good corrosion resistance, heat resistance properties.

## ■ Typical Weld Metal Properties (Chem Pad) :

	C	Si	Mn	Cr	Ni	Mo
AWS A5.22 E308LT0-3	≤0.04	≤1.0	0.5~2.5	19.5~22	9.0~11	≤0.75
<b>K-NGS308L</b> (Typical)	0.018	0.45	1.15	20.5	9.700	0.03

## ■ Welding Positions



PA/1G PB/2F PC/2G

## ■ Current type

※ DCEP (DC(+)) is recommended

## ■ Typical mechanical properties of all-weld-metal

Requirements	Y/S (MPa, Ksi)	T/S (MPa, Ksi)	E.L (%)
AWS A5.22 E308LT0-3	-	≥520 (≥75)	≥30
<b>K-NGS308L</b> (Typical)	490 (71.1)	600 (87.1)	39

After machining, but before testing, the specimen was aged at a temperature 100°C for up to 48 hours then allowed to cool to room temperature.

## ■ Recommended Operating Conditions (DC +)

Wire Dia. " (mm)	Positions	Welding current (A)	Welding Voltage (V)
0.035	F / H-Fillet	80~120	22~26

## ■ Packages

Dia.(")	0.030	0.035
Spool (LB)	1, 2, 10	