

**Classifications**

EN ISO 17633-A:2008	: T 19 9 L P C(M) 1	KS D 3612	: YF-308LC
EN ISO 17633-B:2008	: TS308L-FB1	JIS Z 3323	: TS308L-FB1
AWS A5.22-15	: E308LT1-1/4		

**Description**

- K-308LT is designed for MAG welding of low carbon 18%Cr-8%Ni stainless steel and used to joint austenitic stainless steel (AISI 304, 304L, 304LN, ASTM A157 Gr. C9; A320 Gr. B8C or D)
- The weld metal contains optimum ferrite contents in their austenitic structures, Therefore their weldability is excellent with lower crack susceptibility.
- It has easy slag removal, low spatter generation and good weld soundness of weld-metal.

**Welding positions****Polarity & shielding gas**

- CO<sub>2</sub>: 100% CO<sub>2</sub> (15~25ℓ/min)
- Mix: Ar+20% CO<sub>2</sub> (15~25ℓ/min)
- DCEP (DC+)

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

Shielding gas	C	Si	Mn	Cr	Ni	FN
CO <sub>2</sub>	0.03	0.60	1.15	20.30	10.50	
Mix	0.03	0.65	1.25	20.40	10.50	3~8 & 8~12

**Typical mechanical properties of all-weld metal**

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -40℃	Remarks
AWS A5.22		min. 520	min. 35		
EN ISO 17633-B		min. 520	min. 30		
Example	440	570	39	65	CO <sub>2</sub>
	450	580	38	63	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		

**Approvals**

Shielding gas	ABS	BV	DNV	LR	NK	KR	CCS
CO <sub>2</sub>	E308LT1-1	UP	308L	BF 304L S CHE	KW 308LG(C)	RW 308LG(C)	304L