

SW-308L Cored

TYPE : Rutile

AWS A5.22 / ASME SFA5.22 E308LT1-1/-4
JIS Z3323 TS308L-FB1
EN ISO 17633-A-T 19 9 L P M/C 2

Applications

SW-308L Cored is designed for welding of 18%Cr-8%Ni stainless steels.

Characteristics on Usage

SW-308L Cored is a flux cored wire for all position welding to be used with CO₂ or Argon +CO₂ mixed shielding gases. This wire benefits from a fast freezing slag system which assists the operator when welding out of position and performs equally as well when welding in the flat and horizontal position.

Notes on Usage

① Use with 100% CO₂ or Ar + 20~25% CO₂ gas.

Welding Position



1G 2F 3G 4G
(PA) (PB) (PF) (PE)

Current

DC +

Shielding Gas

CO₂/Ar+20~25% CO₂

Typical Chemical Composition of All-Weld Metal (%) (Shielding Gas: 100% CO₂)

C	Si	Mn	P	S	Cr	Ni
0.03	0.65	1.45	0.025	0.010	19.5	10.0

Typical Mechanical Properties of All-Weld Metal (Shielding Gas: 100% CO₂)

YS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
590 (85,600)	45	-20 (-4)	60 (44)

Approval

I Packing(Including Ball Pac)

ABS, LR, NK, BV, DNV, TÜV, CWB, CE, DB	Dia. (mm) (in)	0.9 .035	1.2 .045	1.6 1/16	Spool(kg) (lbs)	5 11	12.5 28	15 33
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Sizes Available and Recommended Currents (Amp.)

Size mm (in)	0.9 (.035)	1.2 (.045)	1.6 (1/16)
F & HF	130~190	180~220	250~290
V-up,OH	100~140	120~160	-