

Need Metal? We get it!

SpecMet CSF-308L(P)

AWS A5.22 E308LT1-1/4
KS D 3612 YF308LC
JIS Z 3318 T62T1-1C-2C1M
EN ISO 17634-A T (CrMo2) P C 1 - ISO 17634-B T62T1-1C-2C1M

Applications

CSF-308L(P) is suitable for Welding of low carbon 18%Cr-8%Ni Stainless steel(SUS308L).

Characteristics

- (1) CSF-308L(P) is flux cored wire and designed for Fillet & H-F(All-position) welding with CO₂ gas Shielding.
- (2) It provides the excellent usability with stable arc, less spattering, good bead appearance, better slag removal, and less quantity of welding fume comparable to solid wire.
- (3) Is containing Ferrite of a reasonable quantity and crack-resistance, intergranular corrosion resistance, mechanical properties of weld metal is superior.
- (4) Shield gas is 100% CO₂ or Ar+CO₂ gas.

Notes on Usage

- (1) The optimum flow of CO₂ for Shielding is 20~25l/min.
- (2) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.
- (3) Keep the distance between tip & base metal at 15~25mm.

Typical Chemical Composition of Weld Metal (%) (shielding gas: 100% CO₂)

	C	Mn	Si	P	S	Cr	Ni	FN
308L	0.03	1.35	0.65	0.025	0.010	19.3	9.6	8
308LP	0.03	1.45	0.60	0.020	0.007	20.0	9.8	10
^{308LP} CRYOGENIC	0.03	1.43	0.60	0.020	0.009	19.5	10.2	10.2

Typical Mechanical Properties of Weld Metal (%) (shielding gas: 100% CO₂)

	YS N/mm ² (MPa)	TS N/mm ² (MPa)	EL (%)	IV (J) 0° C	IV (J) -196° C
308L	430	570	43	55	-
308LP	415	570	44	54	-
^{308LP} CRYOGENIC	425	580	42	57	38

Size and Recommended Current Range (AC or DC+)

Dia mm (in)	Current (A)	Volatage (V)	Welding Speed (cm/min)
1.2 (0.045)	150~300	24~33	20~60
1.6 (0.062)	200~400	24~33	20~60

Approval : CSF-308L : ABS, BV, DNV, GL, KR, LR, NK / CSF-308LP(for cryogenic) : ABS, BV, DNV, LR