

K-308LT

AWS E308LT1-1/4
JIS YF308LC
KS YF308LC

FOR STAINLESS STEEL

Typical applications

K-308LT is designed for MAG welding of low carbon 18%Cr-8%Ni stainless steels. (AISI 304, 304L, 304LN, ASTM A157 Gr. C9; A320 Gr. B8C or D)

Characteristics on Usage

- ① Wire is a titania type of flux cored wire for all-position welding.
- ② Excellent weldability and increased creep resistance at elevated temperature
- ③ The weld metal contains optimum ferrite contents in their austenitic structures
Therefore their weldability is excellent with lower crack susceptibility.
- ④ The shielding gas should be used 100%CO₂ and 80%Ar+20%CO₂ for welding.
- ⑤ Refer to page 150 for more information on usage.

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

Shielding Gas	C	Si	Mn	Cr	Ni
CO ₂	0.03	0.62	1.56	19.5	10.5
Ar+20%CO ₂	0.03	0.79	1.90	19.8	10.2

Typical mechanical properties of all-weld-metal

Shielding Gas	T · S N/mm ² (kgf/mm ²)	EI (%)
CO ₂	570 {58}	38
Ar+20%CO ₂	610 {62}	35

Sizes available and recommended currents (DC wire⊕)

Dia. (mm)	Amp.	Electrode extension (mm)
1.2	100~220	10~20
1.6	160~260	15~25

Welding positions



Approved by

ABS, BV, CWB, KR, NK, TÜV, JIS
(80%Ar+20%CO₂:CWB, TÜV)