SFA 308L(P)

Stainless steel wires (Fcaw)

Description

SFA 308L(P) is flux cored wire and designed for Fillet & H-F(All-position) welding with CO2 gas Shielding.
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.
Is containing Ferrite of a reasonable quantity and crack-resistance, integranular corrosion resistance, mechanical properties of weld metal is superior.
Shield gas is 100%CO2 or Ar+CO2 gas.
For 18%Cr-8%Ni Stainless Steel.

Notes on usage

The optimum flow of CO2 for Shielding is 20~25ℓ/min.

Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.

Keep the distance between tip & base metal at 15~25mm.

Applications

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

Classification

AWS A5.22 E308LT0(1)-1/-4	KS D 3612 YF308LC	JIS Z3323 TS308L-FB0(1)

Typical weld metal chemical composition (%) (Shielding Gas : 100%CO2)

	C	Mn	Si	P	S	Cr	Ni	FN
SFA 308L	0.03	1.35	0.65	0.025	0.010	19.3	9.6	8
SFA 308LP	0.03	1.45	0.60	0.020	0.007	20.0	9.8	10
SFA 308LP (Cryogenic)	0.03	1.43	0.60	0.020	0.009	19.5	10.2	6

All weld metal mecanical properties (typical) (Shielding Gas : 100%CO2)

	Yield Strength N/mm2(MPa)	Tensile Strength N/mm2(MPa)	EL (%)	IV (J)	
				0°C	-196°C
SFA 308L	430	570	43.0	55	-
SFA 308LP	415	570	44.0	54	-
SFA 308LP (Cryogenic)	425	580	42.0	57	38

Size & recommended current range (DC+)

Dia. mm (in)	Current (A)	Voltage (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