

SFC-308L

AWS A5.22 E308LT1-1
JIS Z3323 TS308L-FC1
EN ISO 17633-A T 19 9 L P C/M 2

FLUX CORED WIRES FOR STAINLESS STEEL

DESCRIPTION :

SFC-308L is a rutile flux cored tubular wire for all-positional welding using pure CO₂ or Argon CO₂ mixed shielding gas. It performs with smooth arc transfer, self-releasing slag, low spatter level, fine ripple and good intergranular corrosion resistance.

APPLICATIONS :

Suitable for welding 18%Cr-8%Ni stainless steels. Typical applications include corrosion resistance overlay, joining of common austenitic stainless steel types 301, 302, 304, 304L, stabilised 321, CF-8 and CF-3.

NOTE ON USAGE :

1. Use DC (+) polarity.
2. Maintain a higher welding speed in order to get enough penetration in the down hand welding position.

WELDING POSITION:



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :(Shielding Gas: 100% CO₂)

Weld Metal Analysis :

Carbon (C)	0.031
Manganese (Mn)	1.55
Silicon (Si)	0.52
Phosphorus (P)	0.021
Sulphur (S)	0.013
Nickel (Ni)	9.83
Chromium (Cr)	19.72

TYPICAL MECHANICAL PROPERTIES OF WELD METAL:(Shielding Gas: 100% CO₂)

TS N/mm ²	562
EL%	42.0

TYPICAL IMPACT VALUES :

IV -196°C J	38
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APPROVALS :

ABS,BV,CCS,CE,DNV · GL,LR,JIS

SUGGESTED WELDING PARAMETERS (DC <+>)

Parameters	1.2mm		1.6mm	
	F, HF	V-UP, OH	F, HF	V-UP, OH
Welding Position				
Voltage (Volt)	23 ~ 33	25 ~ 30	27 ~ 32	--
Current (Amp)	130 ~ 220	120 ~ 200	200 ~ 300	--