FOR STAINLESS STEEL

AWS E308T0-1/-4
JIS YF308C
KS YF308C

K-308T

Typical applications

K-308T is formulated for MAG welding of 18%Cr-8%Ni stainless steels. It is designed for operation primarily in the flat position and for weldling horizontal fillet welds

Characteristics on Usage

① K-308T is a titania type of flux cored wire for AISI 304 type
② Wire has low spatter, easy slag removal and good weld soundness.
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%CO_2 and 80%Ar+20%CO_2 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	0.05	0.60	1.55	19.5	10.5
Ar+20%CO_2	0.04	0.75	1.87	19.7	10.3

Typical mechanical properties of all-weld-metal

Shielding Gas	T · S N/mm²{kgf/mm²}	El (%)
CO_2	580 {59}	38
Ar+20%CO_2	610 {62}	36

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, DNV, KR, NK, JIS