

Descriptions

FCAW EQ308LT1-1/4 is suitable for welding 18% Cr-8% Ni stainless steel (AISI 301、302、304、305、308), with its weld deposit of 19.5% Cr-10% Ni. It provides excellent weldability and crack resistance, due to proper Ferrite contents in the weld metal. It also has stable arc, good slag removal, easy control of weld puddle, low spatters, X-ray quality welds and good penetration.

Welding position: All position

Shielding gas: CO₂ or Ar+20%CO₂

Classification

AWS A5.22 E308LT1-1/4 JIS Z3323 TS308L-FB1 EN 17633-A T19 9 L P C/M21 2

Typical Chemical Composition (All Weld Metal), weight %

Gas	C	Si	Mn	P	S	Cr	Ni		
C1	0.036	0.68	1.62	0.034	0.005	19.09	8.81		
M21	0.034	0.72	1.66	0.029	0.005	19.12	8.75		

Mechanical Properties (All Weld Metal, as welded)

Shielding Gas	C1	M21
Yield Strength, N/mm ²		
Tensile Strength, N/mm ²	550	540
Elongation, %	42	44
Charpy V-Notch @ 0°C, J		

Operating Data

Diameter	1.2mm	1.6 mm
F / H-Fillet	100 – 300	200 – 360
V / OH	100 – 200	-