

## ❖ Product Description

- |   |   |
|---|---|
| I. Gas shielded, extra low carbon, rutile type FCW wire | IV. Uniform and good weld bead appearance |
| II. Low fumes, very less spatter                        | V. Typical 19Cr-10Ni weld deposit         |
| III. Excellent crack resistant and corrosion resistant  | VI. Radiographic weld quality             |

## ❖ Range of Application

- |  |   |
|--|---|
| I. Extremely good for welding of Welding of 18Cr-8Ni stainless steels of AISI 301, 302, 304, 304L type | II. Finds usage in chemical industries, food processing industries, pipes and tubes |
|--|---|

## ❖ Classification

- AWS/SFA 5.22 E308LT1

## ❖ % Chemical Composition

Type of Wire		C	Mn	Si	S	P	Mo	Cr	Ni	Cu
E308LT1	Min	-	0.50	-	-	-	-	18.0	9.0	-
	Max	0.04	2.50	1.0	0.03	0.04	0.75	21.0	11.0	0.75

## ❖ Mechanical Properties of all weld metal

Condition	UTS, Mpa (Min)	YS, MPa (Min)	% Elongation	Charpy "v" Notch Impact @ -30°C
PWHT	520	-	30	-

## ❖ Wire Size & Welding Position

- |                            |                               |
|----------------------------|-------------------------------|
| • Diameter in mm- 1.2, 1.6 | • Weld Position- All position |
|----------------------------|-------------------------------|

## ❖ Current & Gas Flow

- DCEP; 18-25lit/min

## ❖ Packaging

- Standard packaging in 15kg Spool form

### Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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