

**Classifications**

EN ISO 17633-A:2008	: T 19 9 L P C(M) 1	KS D 3612	: YF-308LC
EN ISO 17633-B:2008	: TS308L-FB1	JIS Z 3323	: TS308L-FB1
AWS A5.22-15	: E308LT1-1/4		

**Description**

- K-308LS is designed for MAG welding of low carbon 18%Cr-8%Ni stainless steels and recommended to be used for low temperature service (STS 304, 304L, 304LN, ASTM A157 Gr C9; A320 Gr. B8C or D)
- It is a titania type of flux cored wire for all-position welding and formulated to focus on mechanical properties more than welding arc stability and provides good corrosion resistance, heat resistance properties.
- The weld metal contains low ferrite contents in their austenitic micro structures and provides good corrosion resistance, heat resistance properties.

**Welding positions****Polarity & shielding gas**

- CO<sub>2</sub>: 100% CO<sub>2</sub>
- Mix: Ar+20% CO<sub>2</sub> (15-25ℓ/min)
- DCEP (DC+)

**Typical chemical composition of all-weld metal (%)**

Shielding gas	C	Si	Mn	Cr	Ni	FN
CO <sub>2</sub>	0.03	0.63	1.39	18.55	10.02	3-8
Mix	0.03	0.69	1.24	18.95	10.86	

**Typical mechanical properties of all-weld metal**

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -196°C	Remarks
AWS A5.22		min. 520	min. 35		
EN ISO 17633-B		min. 520	min. 30		
Example	400	550	43	40	CO <sub>2</sub>
	427	587	50	48	Mix

**Notes on usage and welding condition**

- Refer to page 303 for more information on usage
- When heat input is excessive, the impact value tends to be reduced. Therefore, perform welding with selecting proper heat input

**Package**

Dia. (mm)	0.9	1.2	1.6
Spool (kg)	5, 12.5, 15		