

Classifications

AWS A5.22-15 : E308LT0-3

Description

- K-NGS308L is designed for self-shielded welding of low carbon 18%Cr-8%Ni stainless steel and used to join STS 304, 304L, 308, 201, 202, 203 etc.
- It is a lime-titania type of flux cored wire for flat and hofizontal welding position without shielding gas.
- It features easy slag removal, open transfer, low spatter generation, smooth bead surface and high X-ray safety.
- The weld metal contains low ferrite contents in their austenitic micro structures and provides good corrosion resistance, heat resistance properties.
- The wire should be kept in an area of low humidity after usage to protect to absorbed moisture in rainy season or a dewfall environment.

Welding positions**Polarity & shielding gas**

- DC+, Self-shield

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	Cr	Ni	FN
None	0.02	0.45	1.12	20.50	9.70	10.0

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -20°C	Remarks
AWS A5.22		min. 520	min. 35		
Example	440	620	39	85	None

Notes on usage and welding condition

Dia.(mm)	0.8	0.9	1.2
Current (Amp.)	40 ~ 120	60 ~ 140	100 ~ 180
	PA/1G	60 ~ 140	100 ~ 180
	PC/2G	50 ~ 120	60 ~ 140

- It is more convenient to weld with portable welding machine

Package

Dia. (mm)	0.8	0.9	1.2
Spool (kg)	1, 5	12.5, 15, 20	