

FCW

Filler FCW-308LP

for Stainless Steel Flux Cored Wire

CLASSIFICATIONS: AWS A5.22 : E308LT1-1
 EN ISO 17633-A : T 19 9 L P C1 1
 EN ISO 17633-B : TS 308L-F C1 1
 JIS Z 3323 : TS308L-FC1

WELDING POSITIONS :



DESCRIPTION AND APPLICATIONS

Filler FCW-308LP is designed for 100% CO₂ gas shielding and all position flux cored wire for welding type 301,302,304,304L,308 and 308L of austenitic stainless steel. It exhibits very excellent slag detachability and low spatter level.

Also provides better inter-granular corrosion resistance due to low carbon weld deposit.

TYPICAL ALL WELD METAL COMPOSITION (Wt%)

C	Mn	Si	Cr	Ni	Mo	Cu	S	P
0.028	1.41	0.45	19.85	9.75	0.16	0.21	0.012	0.011

- Shielding Gas: 100% CO₂

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES

YIELD STRESS	TENSILE STRENGTH	ELONGATION	CHARPY IMPACT VALUES
400 MPa	560 MPa	38%	30J @ -196°C

SIZES AND RECOMMENDED CURRENT RANGE (DC+)

DIAMETER ϕ (mm)	VOLTAGE (V)	CURRENT (A)	SPOOL (KG)
0.8	17 - 25	50 - 140	5
1.0	19 - 31	70 - 170	12.5
1.2	22 - 36	120 - 220	12.5
1.6	26 - 38	200 - 300	12.5

- Use DC+ polarity and CO₂ as shielding gas.
- Gas flow rate 20 - 25 l/mm.