

# SW-308L Cored

Type : Rutile



### Conformances

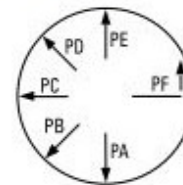
AWS A5.22/ ASME SFA5.22 E308LT1-1/-4  
 JIS Z3323 TS308L-FB1  
 EN ISO 17633-A-T 19 9 L P M21/C1 2  
 ABS AWS A5.22 E308LT1-1 (-120°C 29J)  
 LR 304L (-120°C)  
 BV UP (KV -120°C)  
 DNV-GL VL 308L (-120°C)

NK KW308LG(C)  
 TÜV EN ISO 17633-A-T 199 L P M21/C1 2  
 DB DIN EN ISO 17633-A-T 199 L P M21/C1 2  
 CWB AWS A5.22 E308LT1-1/4  
 CE  
 RS A-5(304L) (C1)

### Applications

- 18%Cr-8%Ni stainless steel

### Welding Position



### Features

- Good porosity resistance

### Current

DC +

### Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	P	S	Cr	Ni	Mo
100% CO <sub>2</sub>	0.019	0.76	1.52	0.015	0.010	18.4	10.6	0.02
80% Ar + 20% CO <sub>2</sub>	0.019	0.76	1.52	0.015	0.010	18.4	9.66	0.02

### Typical Mechanical Properties of All-Weld Metal

	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)
100% CO <sub>2</sub>	567 (82,215)	48.4	-60 (-76)	53 (39.1)
80% Ar + 20% CO <sub>2</sub>	573 (83,085)	48.4	-60 (-76)	54 (39.8)

### Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)
1.2mm (0.045 in) DC+					
100% CO <sub>2</sub>	20 (4/5)	6.2 (244)	140	23-26	2.6 (5.7)
		9.0 (354)	180	27-30	3.8 (8.4)
		12.0 (472)	210	28-31	4.6 (10.1)
80% Ar + 20% CO <sub>2</sub>	20 (4/5)	6.2 (244)	140	23-26	2.7 (5.9)
		9.0 (354)	180	27-30	3.7 (8.3)
		12.0 (472)	210	27-30	4.8 (10.6)

Diam.	15 kg Spool
1.2mm	HKSW30812

TALARC Pty Ltd  
 10-16 Syme St  
 Brunswick, Vic 3056  
 Ph. +61 3 9388 0588 Fax: +61 3 9388 0710  
 W: [www.talarc.com.au](http://www.talarc.com.au) E: [sales@talarc.com](mailto:sales@talarc.com)